

REVISION HISTORY						
DATE	REV	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED	
06/17/16	PR2	ADDED -30, -31, -32 & -33; REMOVED -18, -19, -22, -23, -24, -26, -27, -28 & -29. UPDATED -20 EVAPORATOR TO REMOVE -18, -19, -28 & -29 AND ADDED -31, -32 & -33. REPLACED MS27039-0806 WITH MS27039-0807, ADDED NOTES 4 & 5.	JT	LS	JT	
08/08/16	PR3	CHANGED -6 WIDTH OF FLAT PATTERN FROM 2.841 TO 2.541; ON -8 AND -9, 0.240 DIM. WAS 0.235; ADDED A 0.100 X 5.600 NOTCH TO THE BOTTOM OF -3; ADDED TWO HOLES TO -32 FOR GROUND STUDS; FROM -1, REMOVED ES00140-3 AND MS27039-0808 SCREWS, REPLACED MS21042L08 WITH MS21043-08 NUTS AND MS27039-0807 WITH MS27039-0809; WITH -20, REPLACED -33 ASSY WITH -34, ADDED -35, -36 AND ITEMS #8, 9 & 10.	JT	LS	JT	
03/08/17	A	REMOVED -36; CHANGED THICKNESS OF -35 WAS 0.125"; ADDED FINISH COAT TO -2, -3, -5, -7, -8 AND -9; REMOVED NOTES FROM SHT 2; ADDED NOTES 6 AND 7; ON -5 CHANGED COUNTERSINK HOLE DIA. WAS 0.098 AND ADDED HOLE DIA. 4X 0.093/0.103; ADDED NOTES 8 AND 9 ON SHT 2; CHANGED THE FINISH ON -2, -3, -5, -7, -8, -9, -31 AND -32; ON -8/-9 ADDED 0.177 HOLE DIA DIMENSION; ADDED MASKING AREAS TO -2, -3, -5, -8, -9, -31 AND -32; UPDATED NOTES 1, 2 AND 3; ADDED FASTENER TORQUES; ON -34 UPDATED BEAD DIMENSIONS; ON -20 CHANGED ITEM #7 NUT FROM MS21083N3 TO MS21043-3 AND ITEM #8 SCREW FROM MS27039-1-12 TO MS35207-266; NOTE 3, WAS TABLE 2.	JT	LS	JT	
3/31/17	B	REPLACED MS21043-08 AND MS21043-3 WITH MS21042L08 AND MS21042L3 RESPECTIVELY ON -1 AND -20, REPLACED MS21062-L3 WITH MS21061L3 ON -6. MATERIAL THICKNESS WAS .020" ON -3 AND 0.060" ON -5, ADDED NOTE 10 AND SEALANT NOTE TO SHT 2, ADDED CLOSED CELL FOAM NOTE TO MATERIAL SPEC SHT 16, RELOCATED GROUNDING STUDS FROM -32 TO -31, CREATED -11 ASSEMBLY AND ADDED WIRING HARNESS TO -11 & -10, ADDED ADDITIONAL MASKING DISCS TO -31 & -32.	EW	LS	JT	
6/7/17	C	SHT 4 FIXED VIEWS WHERE RELAY WAS NOT VISIBLE, ITEM 2 WAS 505AC-6100-13; SHT 10 ADDED FINISH AND COLOR SPECIFICATIONS.	EW	LS	JT	
7/12/17	D	MOVED REVISION BLOCK TO NEW SHT 1; -20 ADDED ITEM 15 UNDER 18 SCREW HEAD DETAIL H, ITEM 18 WAS NAS1801-3-14, ITEM 14 WAS MS21042L3; -35 MATERIAL WAS 0.250" THK K-FLEX INSUL-SHEET PSA' CLOSED CELL FOAM SHEET, FLAME RESISTANT PER ASTM E84 CLASS A, REV B & C AUTHOR WAS ETW, FILLED IN CHECKED BY AND APPROVED INITIALS REV'S PR2 TO C.	EW	LS	JT	
9/22/17	E	-1 ASSY, ADDED NOTE #8 FOR FINISH AND ITEM NUMBER BALLOONS FOR 10, 15, 16 & 21. REMOVED "SEALANT TO BE PROVIDED BY INSTALLING FACTORY" FROM NOTE #12 ON SHT. 3.	PM	LS	JT	
10/17/17	F	SHT. 17 ADDED VENDOR AND VENDOR P/N NOTE TO.	EW	LS	JT	
02/21/18	G	SHT 2 ITEM 1 SWAPPED ALT. AND PRIMARY P/N'S, NOTE 8 COLOR WAS 37208; SHT 3 ITEM 1 DESCRIPTION WAS AFT EVAPORATOR ASSY, ADDED MOTOR GND & RELAY GND REF'S, ADDED ITEM 19 TO IMPROVE GROUNDING AND REMOVED 2X ITEM 16; SHT 5 ADDED NOTE 2; SHT 6 ITEM 3 CORRECTED P/N FROM NY3; SHT 7 ADDED BEND CHART & NOTES; SHT 8 ADDED "BOTH SIDES" TO MASKING NOTE; SHT 11 ADDED BEND CHART & NOTE; SHT 12 -5 ADDED BEND CHART & NOTE, AND REF .931 BEND LINE DIM; SHT 14 ADDED BEND CHART & NOTES; SHT 15 -31 DIA0.201 QTY WAS 4, ADDED BEND CHART & NOTES, ADDED +0.020/-0.00 TOL TO PUNCHED HOLE; SHT 16 -32 ADDED BEND CHART & NOTES, ADDED +0.020/-0.00 TOL TO PUNCHED HOLE.	EW	LS	JT	
7/3/18	H	SHT 2, ADDED PRIMER SPECIFICATION TO NOTE 8, INCREMENTED NOTE 11 BY 1; SHT 3, INCREMENTED NOTES 8,9,10,11,12 BY 1, CHANGED NEW NOTE 13 WAS ABOUT SEALANT, NOW ABOUT ELECTRICAL BONDING. SEALANT APPLIED AT FACTORY; SHT 5, INCREMENTED NOTE 11 BY 1; SHT 7, INCREMENTED NOTES BY 1, INSIDE HOLES CHANGED FROM 8X .201 TO 4X .250; SHT 8, CHANGED B3 DIMENSION FROM EDGE TO HOLE, ADDED CENTERLINES; SHT 9, INCREMENTED NOTES BY 1, INSIDE HOLES CALLED AS .250", OUTSIDE CALLED AS .201"; SHT 12, INCREMENTED NOTES BY 1, INCREASED PRECISION ON PART WIDTH DIMENSION; SHT 13, INCREMENTED NOTES BY 1, CHANGED TO ORDINATE DIMENSIONS, INCREASED HOLE PRECISION; SHT 14, INCREMENTED NOTES BY 1; SHT 15, INCREMENTED NOTES BY 1; SHT 16, INCREMENTED NOTES BY 1; ADDED SHEETS 19-22, 505AC-4400-40 ASSY AND -37,-38 PARTS FOR 505AC-440-3 BELL S/N 65170 AND SUBSEQUENT	ZA	LS	MH	
4/2/19	J	ADDED -10 ASSEMBLY; PART -2, -3, 5, -7, -8: CHANGED PAINT TO MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038 WITH GLOSS RATING, OLD PAINT IS ALTERNATE; -2 & -5: ADDED HOLES FOR 505AC-443 INSTALLATION; CHANGED -35 TO -35A AND -35B TO BETTER FIT EVAP COWL; ADDED -36 ASSY, REPLACES -34 & -35 ON THE -40 ASSY, INCREMENTED SHTS 19-23 BY 1; PART -38: UPDATED BEND CHART DIMENSIONS;	ZA	LS	ZA	
7/10/19	K	-1 ASSY: CORRECTED QTY OF ITEMS 12 & 8; -10 ASSY REMOVED; -4 PART: ADDED SCREEN MATERIAL AS 3003-H14 ALUMINUM; -38 PART: ADDED GT00437 POWDERCOAT DISC LOCATION	ZA	LS	ZA	
10/24/19	L	NOTE 4: ADDED DOW CORNING RTV-732 BLACK AS POSSIBLE SEALANT; -1 ASSY: ITEM 13 NOW MS20426AD3-3 WAS CCR264SS3-3; -36 ASSY: CORRECTED TO QTY 2 OF EACH INSULATION PART	ZA	LS	ZA	
10/13/21	M	-1 & -10 ASSY: REPLACED ITEM 4 AND HARDWARE WITH NEW -41 ASSY; -5 & -15: RENAMED TO FWD MOUNT BRACKET TO MATCH ASSY BOM; ADDED -41 ASSY	ZA	DT	ZA	

		TITLE		DRAWING NUMBER	
		EVAPORATOR ASSEMBLY		505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD BY JT	DATE 3/4/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING 	3RD ANGLE PROJECTION	REV M ECO	
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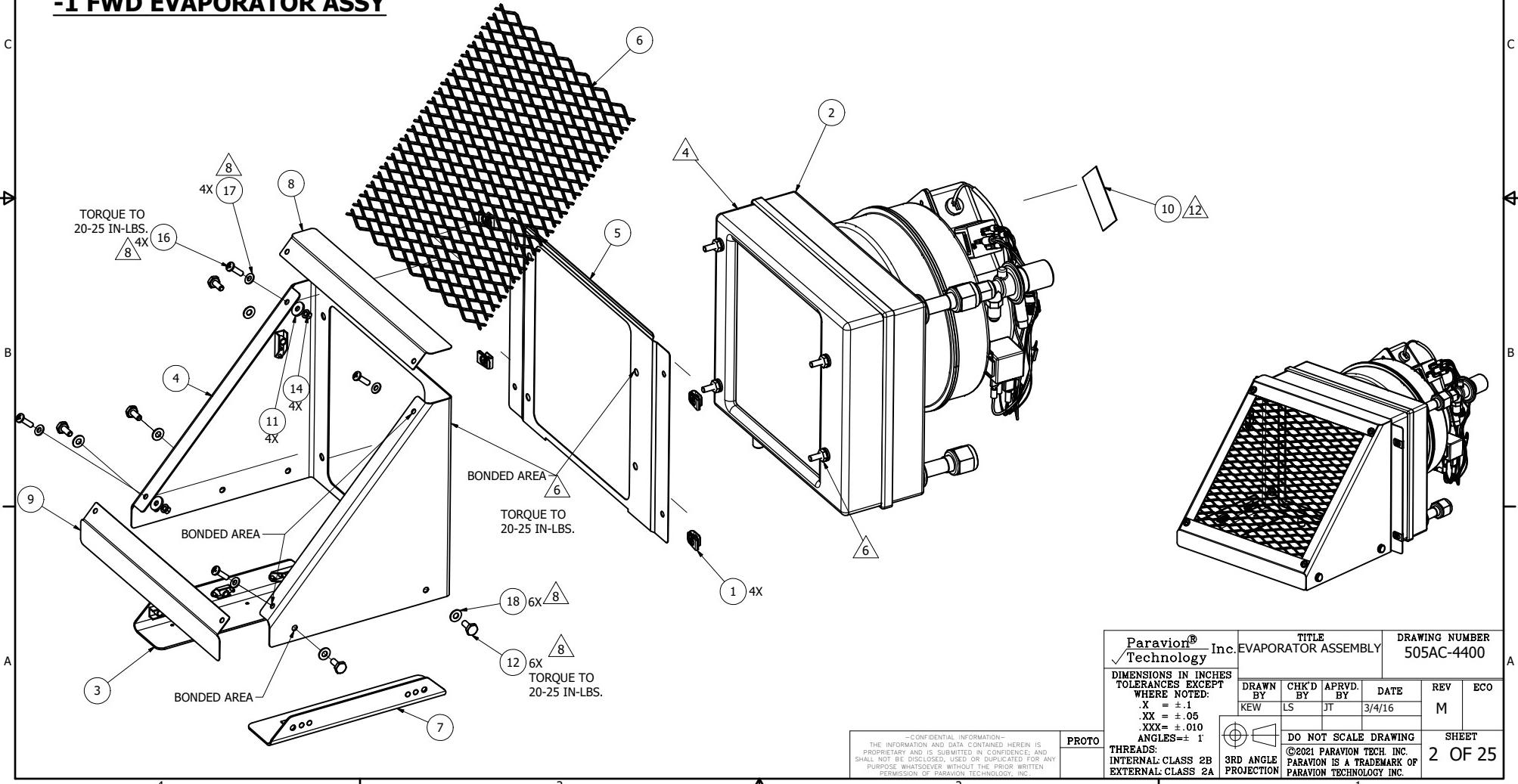
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	130008	NUT PLATE (ALT. #13080017)
2	1	505AC-4400-11	FWD EVAPORATOR
3	1	505AC-4400-16	FWD EVAPORATOR BASE
4	1	505AC-4400-41	LH EVAPORATOR MOUNT ASSY
5	1	505AC-4400-3	FWD EVAPORATOR DOUBLER
6	1	505AC-4400-4	SCREEN
7	1	505AC-4400-6	FWD EVAPORATOR BASE
8	1	505AC-4400-8	INLET TOP TRIM
9	1	505AC-4400-9	INLET BOTTOM TRIM
10	1	505AC-6120-3	LABEL
11	4	9125A5318	WASHER
12	6	AN3-3A	BOLT
14	4	MS21042L08	NUT
16	4	MS27039-0809	SCREW
17	4	NAS1149DN832K	WASHER
18	6	NAS1149F0332P	WASHER

NOTES

1. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPARED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
 2. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25 AFTER ASSEMBLY.
 3. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
 - 4. SEAL MATING SURFACES W/ PEMATEX BLACK RTV #16B, DOW CORNING RTV-732 BLACK, OR EQUIV.
 - 5. ADHERE W/ PERMATEX QUICKGEL #81778 OR EQUIV.
 - 6. USE NUTS AND WASHERS FROM EVAPORATOR TO SECURE MOUNT (4 PLCS).
 - 7. PREPARE SURFACE BY WIPE WITH ISOPROPYL ALCOHOL.
 - 8. APPLY PRIMER PER MIL-PRF-23377J TYPE I, CLASS N. FINISH PER MIL-PRF-85285 TYPE 1 CLASS H, COLOR 37038 BLACK WITH A 20° SHEEN INDEX AT 9 MAX.

-1 FWD EVAPORATOR ASSY



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-12	AFT EVAPORATOR
2	1	505AC-4400-31	EVAPORATOR LEFT SIDE BRACE
3	1	505AC-4400-32	EVAPORATOR RIGHT SIDE BRACE
4	1	505AC-4400-34	EVAP INLET COWL
5	1	505AC-4400-35	EVAP INLET COWL INSULATION
6	1	505AC-6120-13	2100GD3 DECAL
7	1	505AC-6120-14	2100GD4 DECAL
8	1	505AC-6120-26	2160K4 DECAL
9	1	505AC-6120-27	2160K3 DECAL
10	1	505AC-6120-28	2160CR4 DECAL
11	1	505AC-6120-29	2160CR3 DECAL
12	1	505AC-6120-4	LABEL
13	2	AN315-3R	NUT
14	2	NAS9926-3L	LOCKING NUT
15	4	MS35338-43	SPLIT LOCK WASHER
16	2	NAS1149D0332J	WASHER
17	4	NAS1149F0332P	WASHER
18	2	NAS1801-3-12	SCREW
19	2	MS35333-39P	LOCK WASHER

NOTES CONT:

9. PREPARE PART FOR PRIMER:

- a. USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
- b. THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
- c. USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.

10. PAINT ADHESION TEST:

FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.

a. DRY TAPE TEST DONE ONCE EVERY LOT.

i. PLACE THE TAPE ON THE PRIMED SURFACE AND AFFIX WITH FIRM PRESSURE.

ii. REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).

iii. LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.

b. WET TAPE TEST DONE ONCE PER LOT.

i. SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS.

(ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)

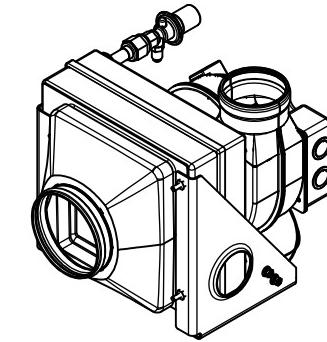
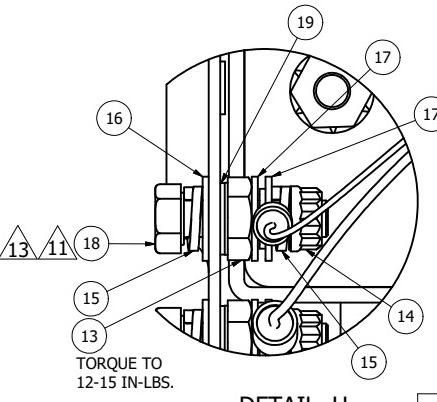
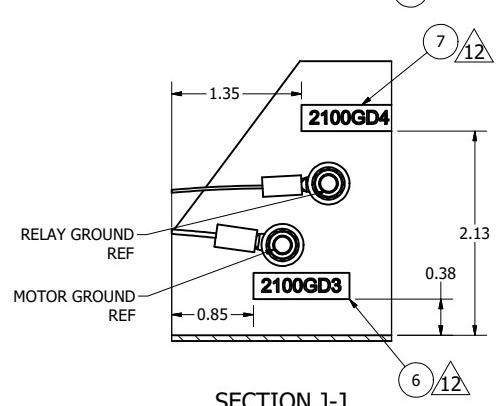
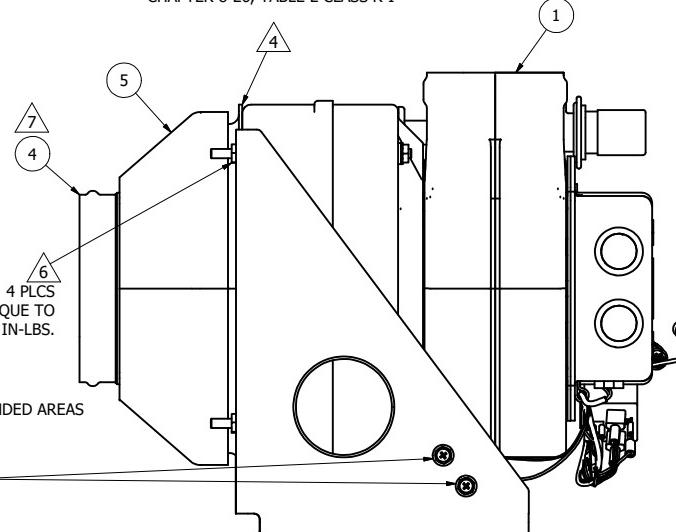
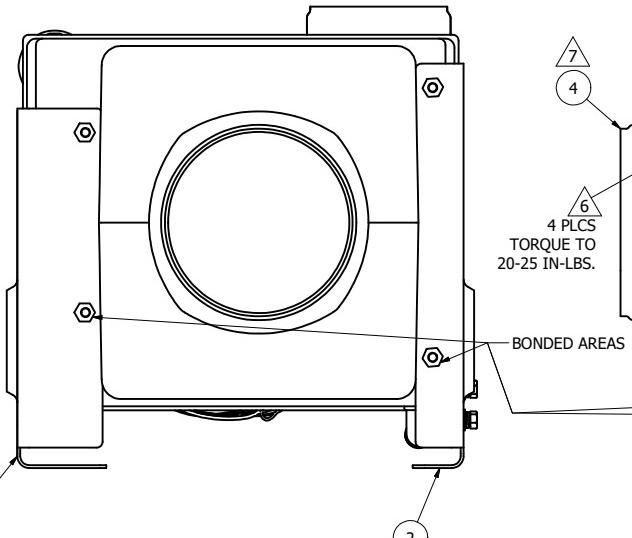
ii. DRY THE SURFACE WITH A CLEAN CLOTH.

iii. REPEAT STEPS i THRU iii OF DRY TAPE TEST.

11. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS R - I (2.5 MILLIOHMS).

12. INSTALL DECAL IN ACCORDANCE WITH BHT-ALL-SPM, CHAPTER 8, PARAGRAPH 88-24

13. FOLLOW SURFACE PREPARATION AND FINISHING PROCEDURES IN BHT-ELEC-SPM CHAPTER 8 FOR ALUMINUM SURFACES. ALL ELECTRICAL BONDING AND GROUNDING TO BE DONE IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 2 CLASS R-I

**-20 AFT EVAPORATOR ASSY**DETAIL H
TYP. 2 PLCS

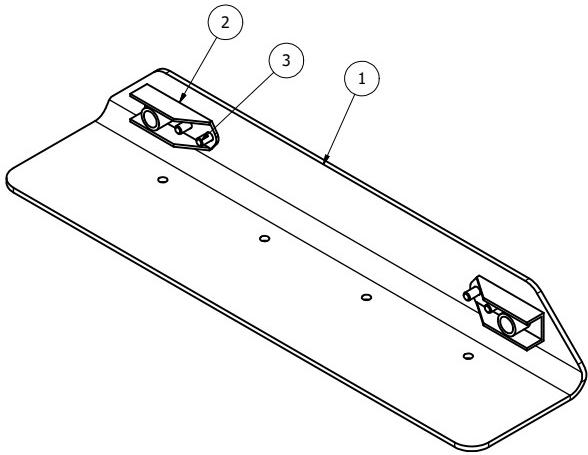
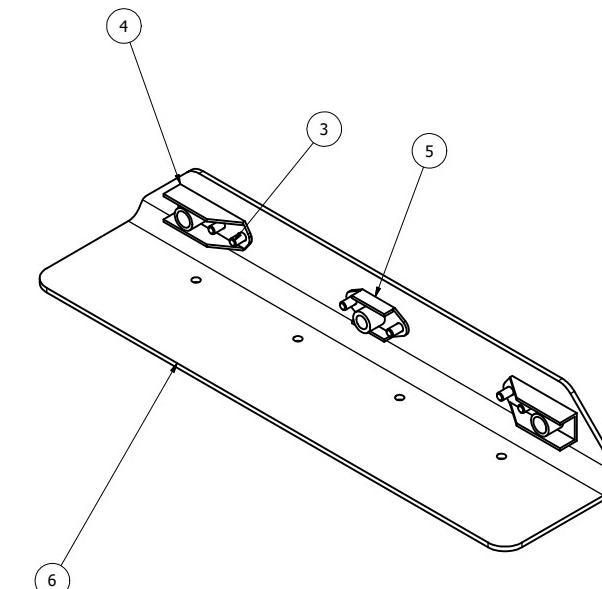
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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		EVAPORATOR ASSEMBLY		505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		REV M	ECO		
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-5	FWD MOUNT BRACKET
2	2	MS21061L3	NUT PLATE ONE LEG FLOATING
3	4	MS20426AD3-4	RIVET

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
3	6	MS20426AD3-4	RIVET
5	1	MS21059L3	NUT PLATE FLOATING
4	2	MS21061L3	NUT PLATE ONE LEG FLOATING
6	1	505AC-4400-15	FWD MOUNT BRACKET

-6 FWD EVAPORATOR BASE**-16 FWD EVAPORATOR BASE**

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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX= ± .010 ANGLES=± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO
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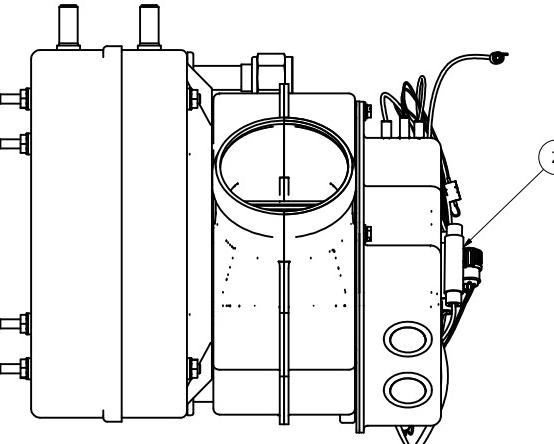
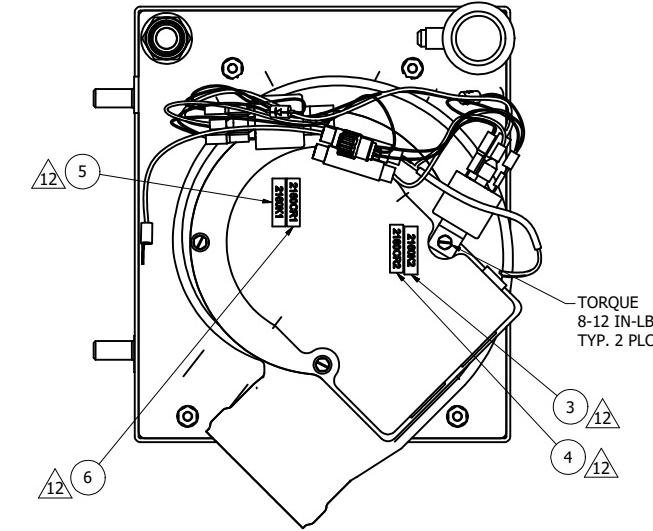
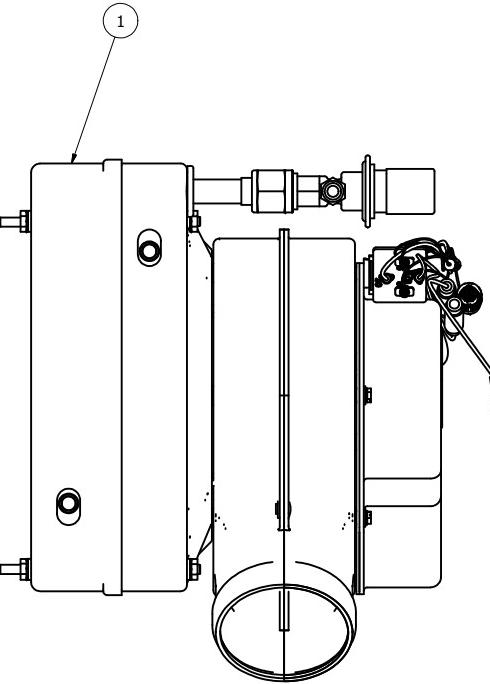
3RD ANGLE
PROJECTION

PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ES75203-1	EVAPORATOR
2	1	505AC-6100-11	FWD EVAPORATOR WIRING ASSY
3	1	505AC-6120-30	2160K2 DECAL
4	1	505AC-6120-31	2160CR2 DECAL
5	1	505AC-6120-32	2160K1 DECAL
6	1	505AC-6120-33	2160CR1 DECAL

-11 FWD EVAPORATOR**NOTES:**

1. APPLY LACING CORD PER BHT-ELECT-SPM CHAP 6, §6-22 THRU 6-29 AS APPLICABLE.
2. CHECK ES75203-1 DRAIN HOLE LOCATIONS WITH 505AC-4400-36 TEMPLATE BEFORE ASSEMBLY.



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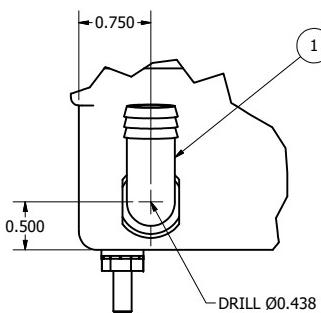
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PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ES49008-4	ELBOW
2	1	ES75202-4	EVAPORATOR
3	1	NY3-C	CABLE CLAMP
4	1	505AC-6100-12	AFT EVAPORATOR WIRING ASSY

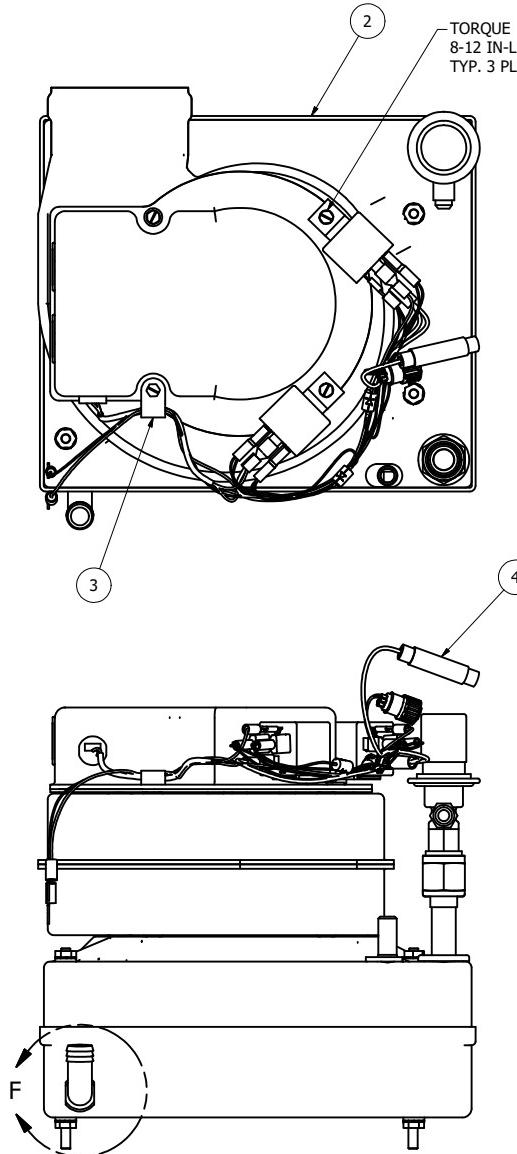
-12 AFT EVAPORATOR**NOTE:**

APPLY LACING CORD PER BHT-ELECT-SPM
CHAP 6, §6-22 THRU 6-29 AS APPLICABLE.



DETAIL F
SCALE 1 : 1

BREAK ALL SHARP EDGES



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-2 LH EVAPORATOR MOUNT

MATERIAL: 0.040" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

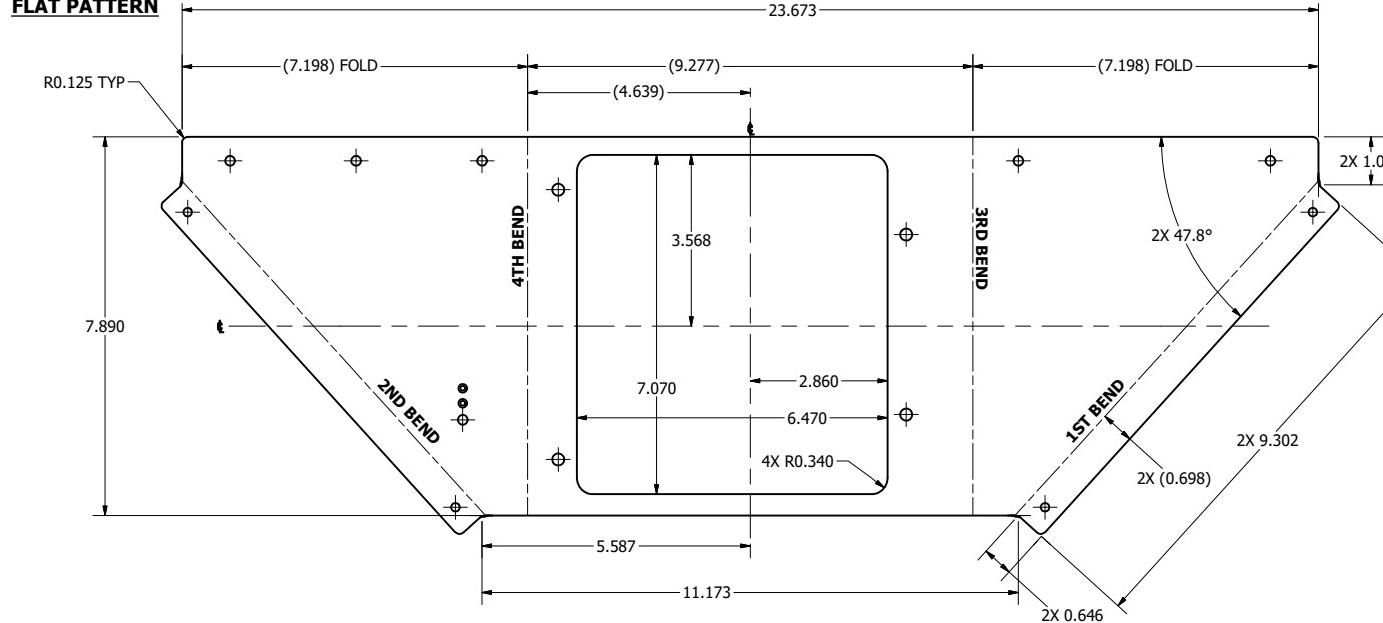
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:

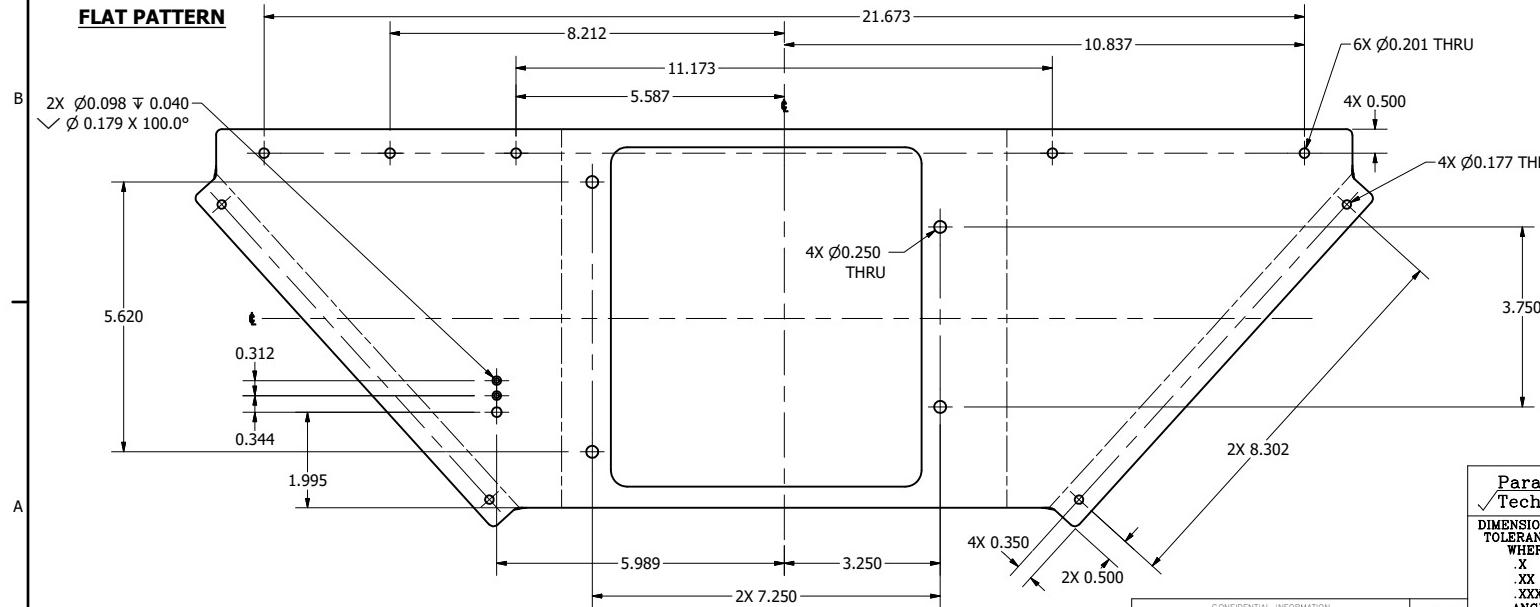


FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038. GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°.

(ALT: BTHI CONSUMABLES LIST #C265)

FLAT PATTERN

	1st BEND	2nd BEND	3rd BEND	4th BEND
PUNCH	#9	#9	#9	#9
DIE	#20	#20	#20	#20
ANGLE	87°	87°	87°	87°
DIMENSION	.708	.708	7.208	7.208

FLAT PATTERN**BREAK ALL SHARP EDGES**

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KEW		LS	JT	3/4/16	M	
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7 OF 25

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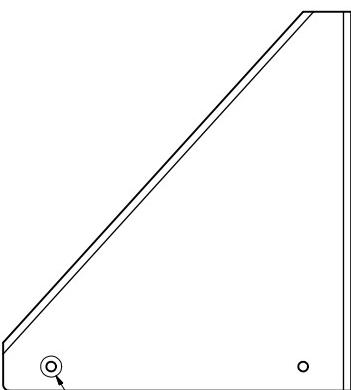
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EXTERNAL: CLASS 2A

ANGLES=± 1°

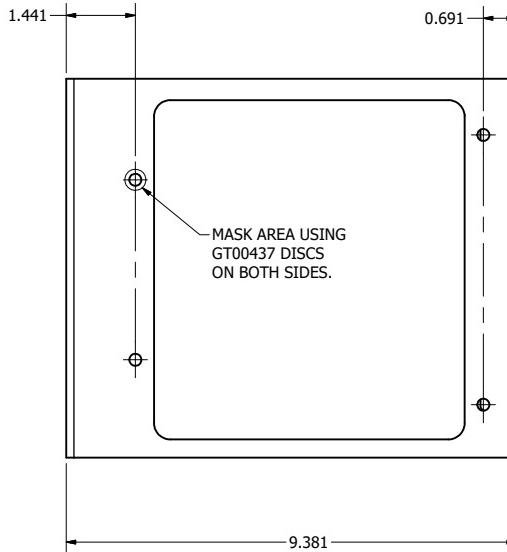
XX = ± .05

XXX= ± .010

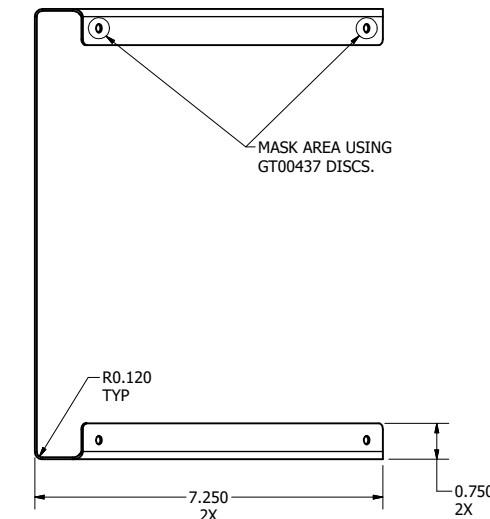
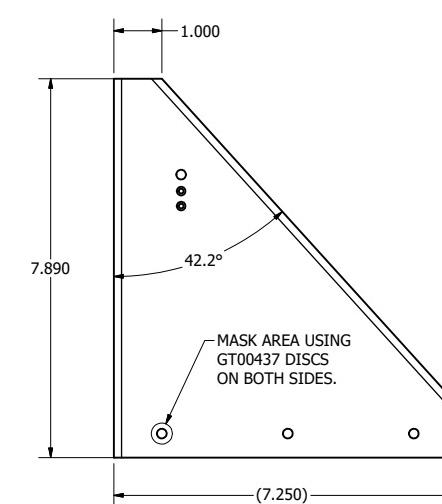
.X = ± .1

-2 LH EVAPORATOR MOUNT CONT.

MASK AREA USING
GT00437 DISCS
ON BOTH SIDES.



9.381



MASK AREA USING
GT00437 DISCS.

R0.120
TYP
7.250
0.750
0.750
2X

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PROTO

Paravion® Technology		TITLE EVAPORATOR ASSEMBLY		DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°				REV M	
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING ©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		SHEET 8 OF 25	

-3 FWD EVAPORATOR DOUBLER 

MATERIAL: 0.020"/.025" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

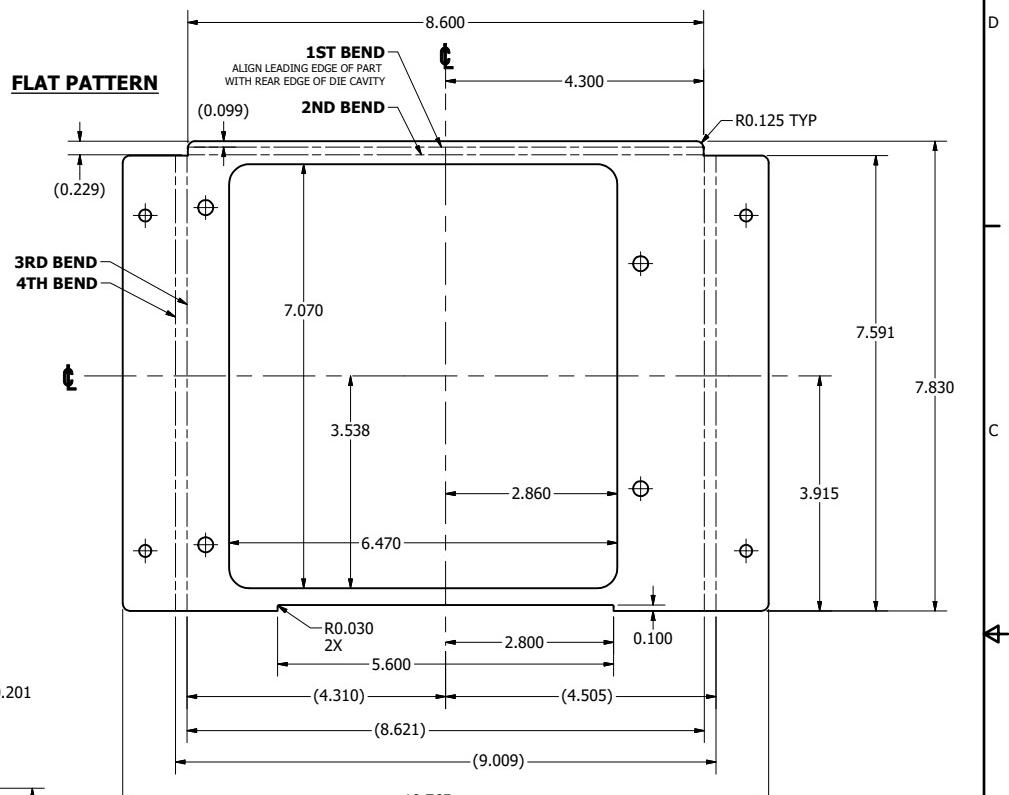
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 

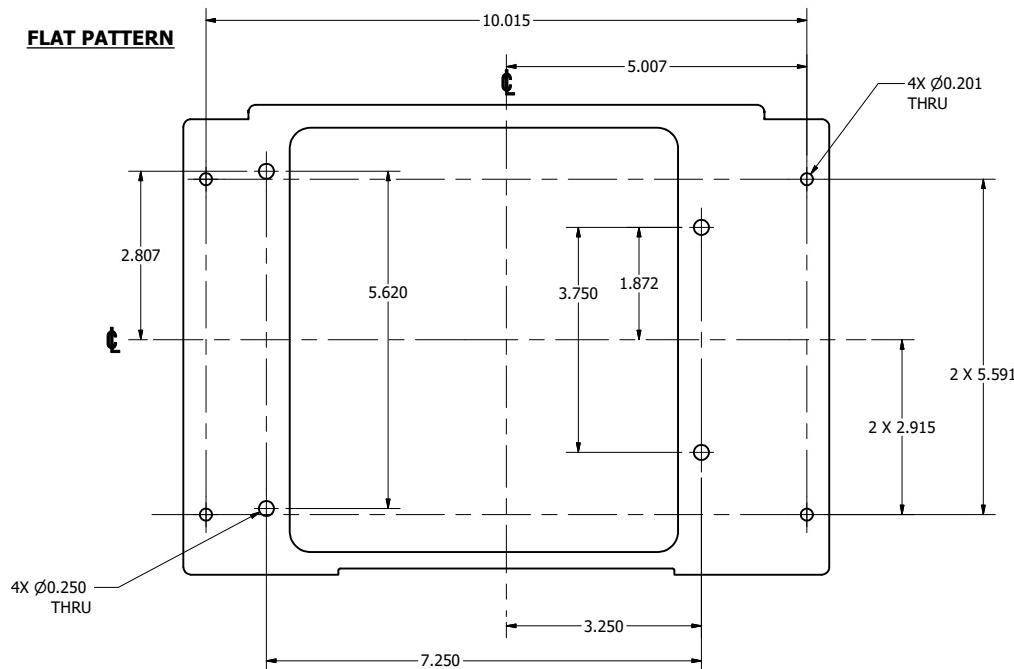
FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038.

GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°.

(ALT: BTHI CONSUMABLES LIST #C265)



BEND CHART				
	1st BEND	2nd BEND	3rd BEND	4th BEND
PUNCH	#6	#6	#6	#6
DIE	#4	#4	#4	#4
ANGLE	155°	155°	155°	155°
DIMENSION	SEE BEND NOTE	.229	1.065	.876

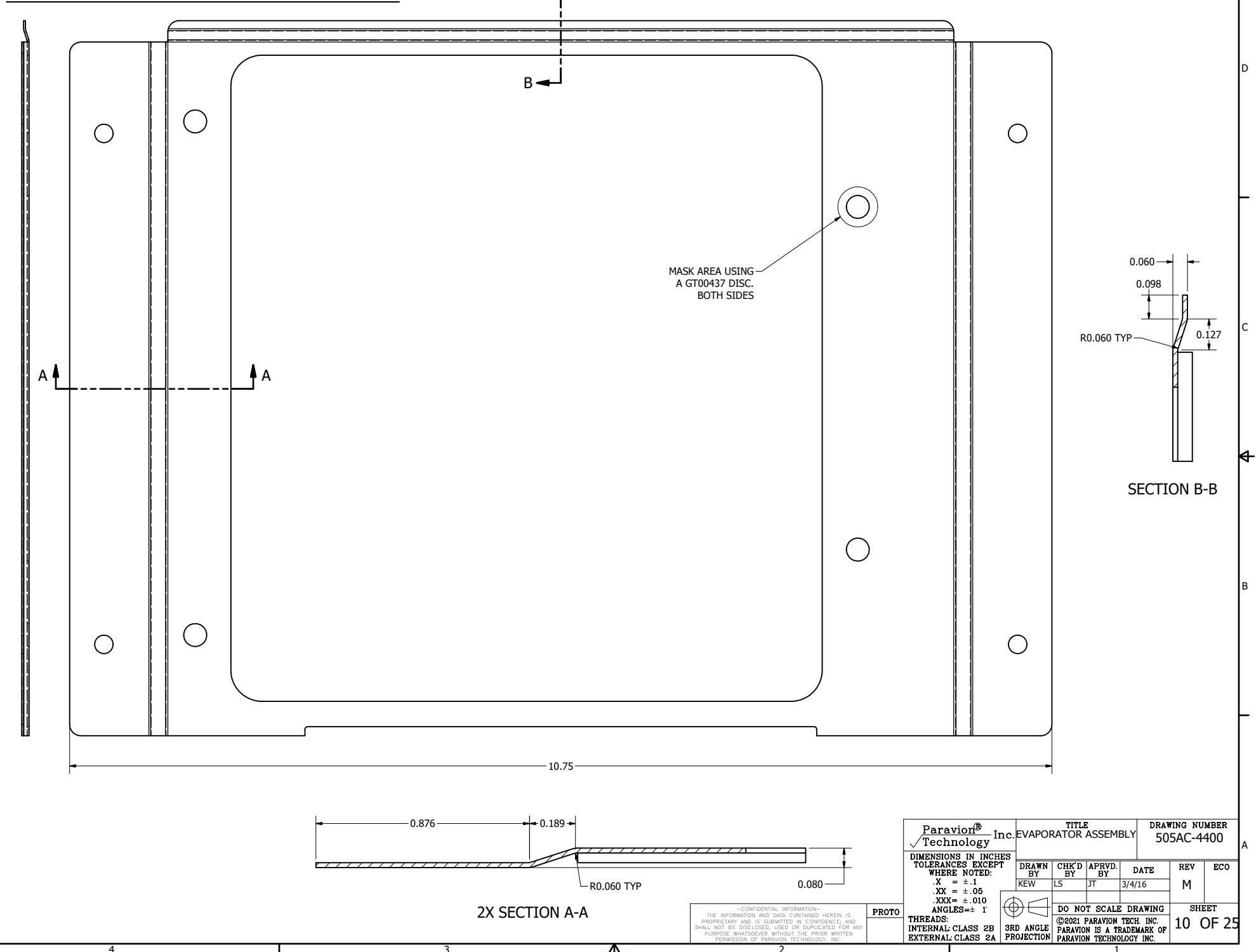
**BREAK ALL SHARP EDGES**

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PROTO

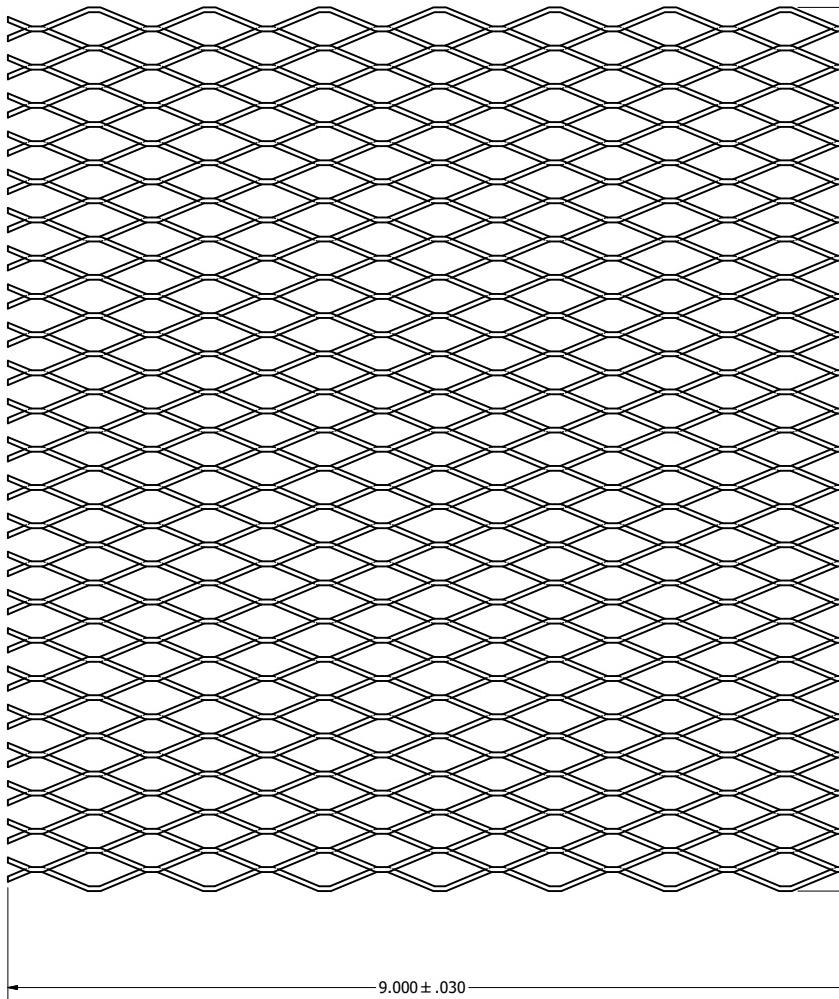
Paravion® Inc. Technology	TITLE EVAPORATOR ASSEMBLY			DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION		©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

SHEET
9 OF 25

-3 FWD EVAPORATOR DOUBLER CONT.

-4 SCREEN

MATERIAL: MADE FROM ES04070-2 SCREEN, 3003-H14 ALUMINUM
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK



BREAK ALL SHARP EDGES

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PROTO

Paravion® Inc. Technology		TITLE EVAPORATOR ASSEMBLY		DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16		REV M
DO NOT SCALE DRAWING ©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					ECO
3RD ANGLE PROJECTION		SHEET 11 OF 25			

-5 FWD MOUNT BRACKET

MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

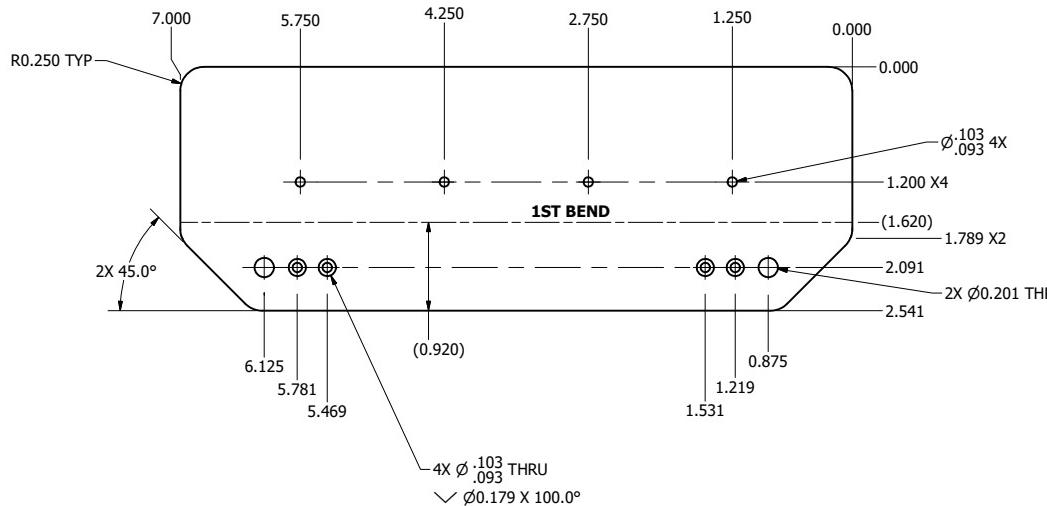
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

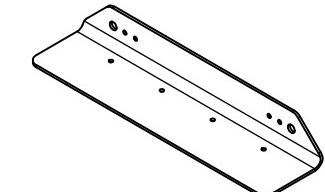
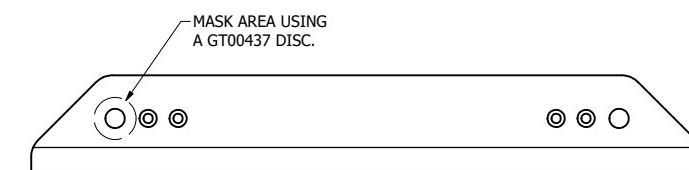
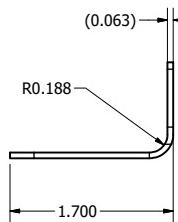
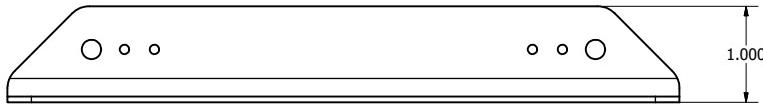
PAINT ADHESION TEST:¹⁰

FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038. GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°.

(ALT: BTHI CONSUMABLES LIST #C265)

FLAT PATTERN

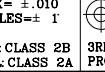
BEND CHART	
	1st BEND
PUNCH	#10
DIE	#20
ANGLE	82°
DIMENSION	.931

**BREAK ALL SHARP EDGES**

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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD BY JT	DATE 3/4/16	REV M	ECO
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THREADS:
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A
PROJECTION: 3RD ANGLE
SHEET
12 OF 25

-15 FWD MOUNT BRACKET

MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

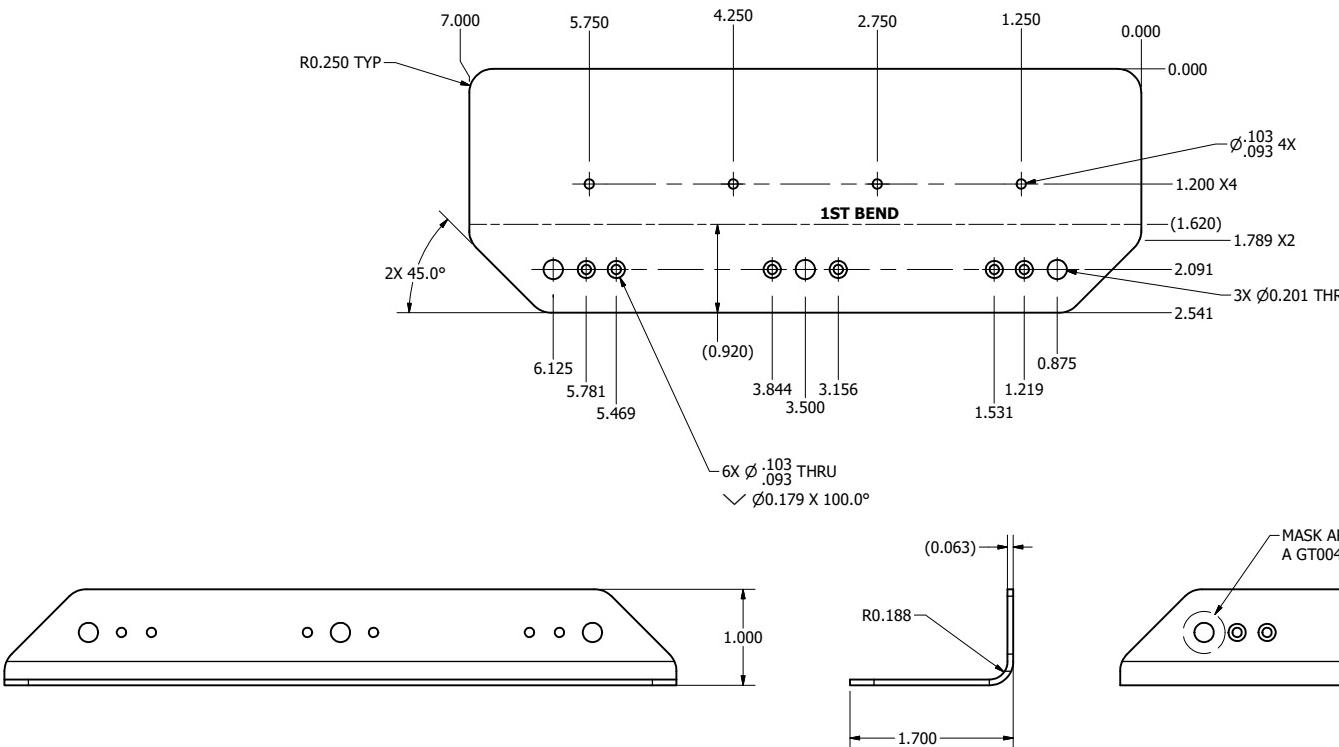
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:¹⁰

FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038. GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°.

(ALT: BTHI CONSUMABLES LIST #C265)

FLAT PATTERN

BEND CHART	
	1st BEND
PUNCH	#10
DIE	#20
ANGLE	82°
DIMENSION	.931

BREAK ALL SHARP EDGES

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PROTO

Paravion® Inc. Technology		TITLE EVAPORATOR ASSEMBLY		DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO
DO NOT SCALE DRAWING					
 3RD ANGLE PROJECTION		SHEET 13 OF 25			
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-7 FWD STIFFENER 

MATERIAL: 0.040" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

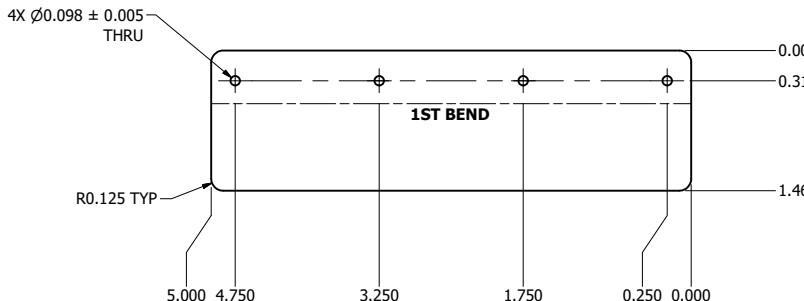
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

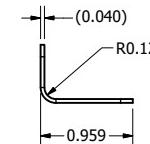
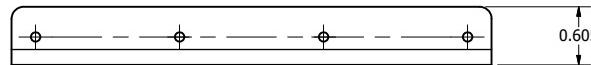
PAINT ADHESION TEST: 

FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038. GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°.

(ALT: BTHI CONSUMABLES LIST #C265)

FLAT PATTERN

BEND CHART	
	1st BEND
PUNCH	#9
DIE	#1
ANGLE	78°
DIMENSION	.563

**BREAK ALL SHARP EDGES**

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Paravion® Inc. Technology	TITLE EVAPORATOR ASSEMBLY			DRAWING NUMBER 505AC-4400		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°						
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO	
DO NOT SCALE DRAWING						
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			SHEET 14 OF 25	
3RD ANGLE PROJECTION						

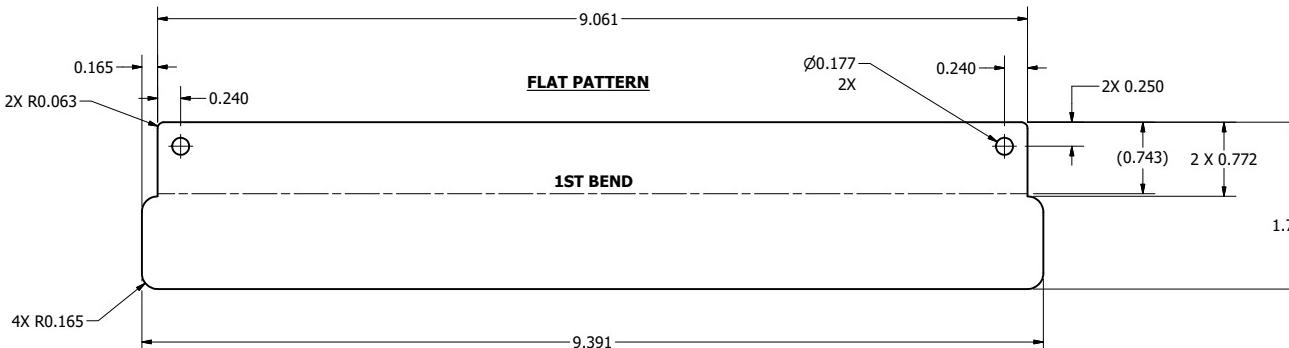
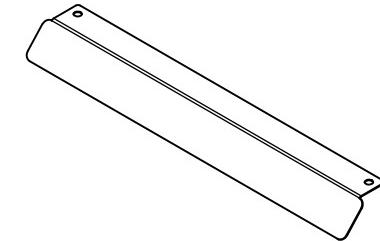
-8 INLET TOP TRIM/ -9 INLET BOTTOM TRIM

MATERIAL: 0.020"/.025" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 10

FINISH: MIL-PRF-85285, TYPE 1, CLASS H, COLOR 37038. GLOSS: 5 UNITS MAXIMUM AT 60° AND 9 UNITS MAXIMUM AT 20°
(ALT: BTHI CONSUMABLES LIST #C265)



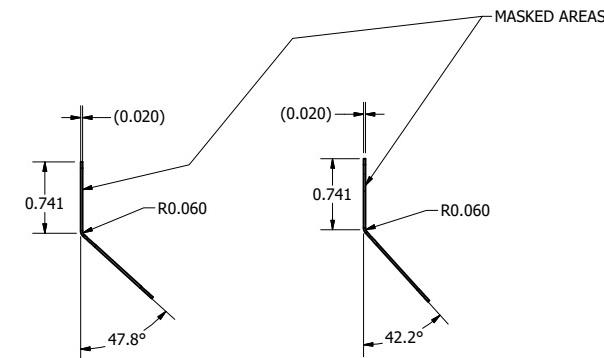
FLAT PATTERN

1ST BEND

4X R0.165 — 9.391 —

A diagram showing a long, thin, horizontal rectangular component. It has a thick black border and two small circles with concentric arcs at the top-left and top-right corners, representing mounting holes or fasteners.

-9 ONLY
MASK AREA USING
A GT00437 DISC
ON THE OPPOSITE SIDE.



PEND CHART

BEND CHART	
	1st BEND
PUNCH	#6
DIE	#4
ANGLE	133°
DIMENSION	.733

BEND CHART

	1st BEN
PUNCH	#6
DIE	#4
ANGLE	138°
DIMENSION	.743

BREAK ALL SHARP EDGES

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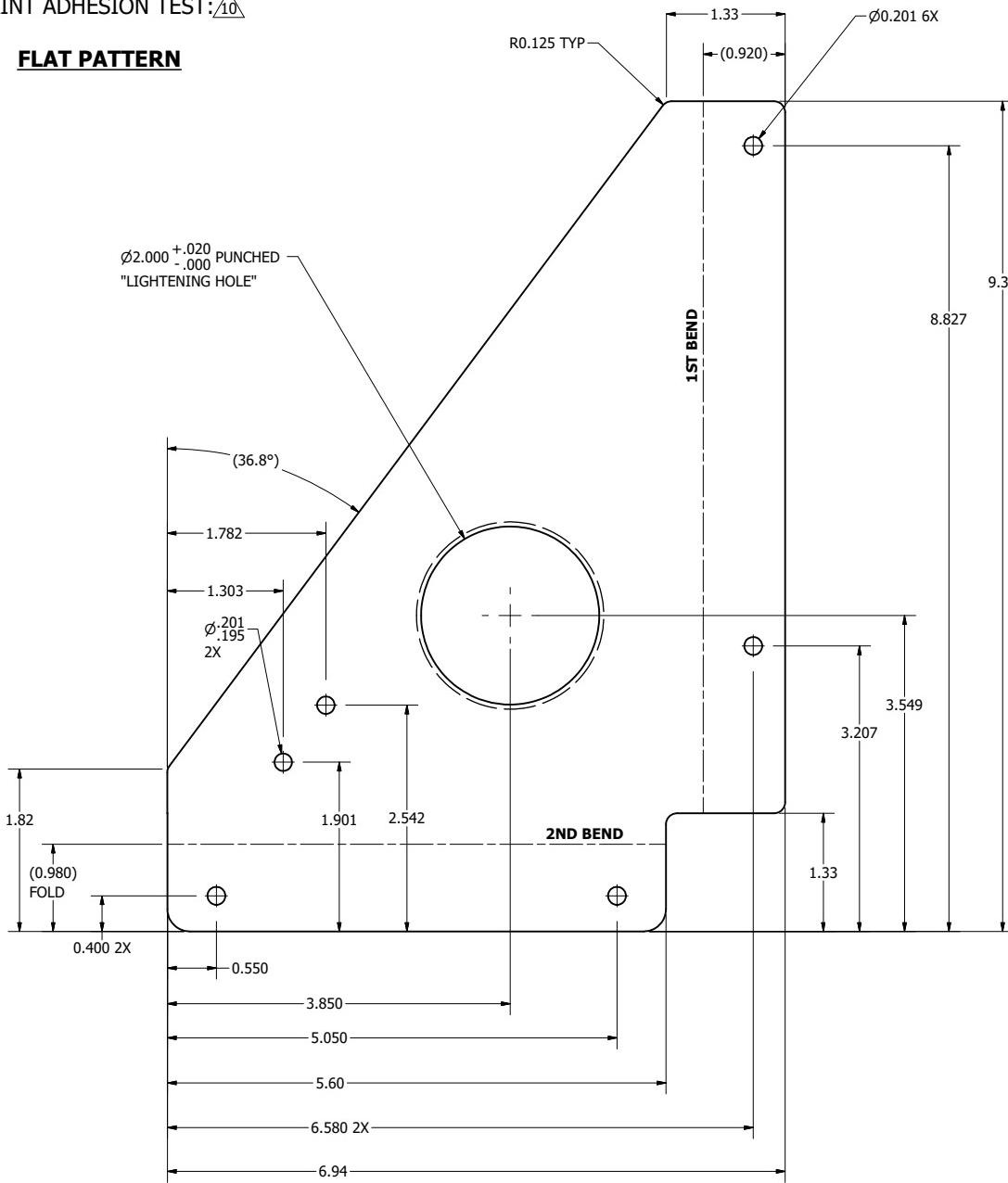
Paravion® Technology	TITLE EVAPORATOR ASSEMBLY			DRAWING NUMBER 505AC-4400		
	DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:	DRAWN BY	CHK'D BY	APPRVD. BY	DATE	REV
X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°	KEW	LS	JT	3/4/16	M	
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A	 3RD ANGLE PROJECTION			DO NOT SCALE DRAWING		SHEET
©2021 PARAVION TECH INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.						15 OF 25

-31 EVAPORATOR LEFT SIDE BRACE 

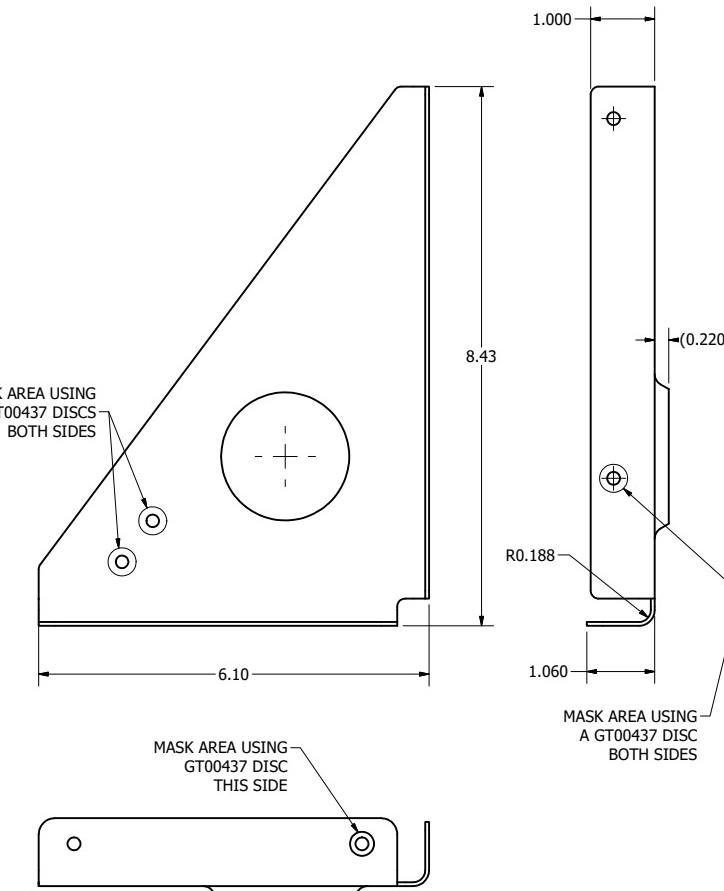
MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:**FLAT PATTERN**

	1st BEND	2nd BEND
PUNCH	#10	#10
DIE	#20	#20
ANGLE	82°	82°
DIMENSION	.930	.990



BREAK ALL SHARP EDGES

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Paravion® Technology	TITLE EVAPORATOR ASSEMBLY			DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO
DO NOT SCALE DRAWING					
SHEET 16 OF 25					
3RD ANGLE PROJECTION		©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

-32 EVAPORATOR RIGHT SIDE BRACE 

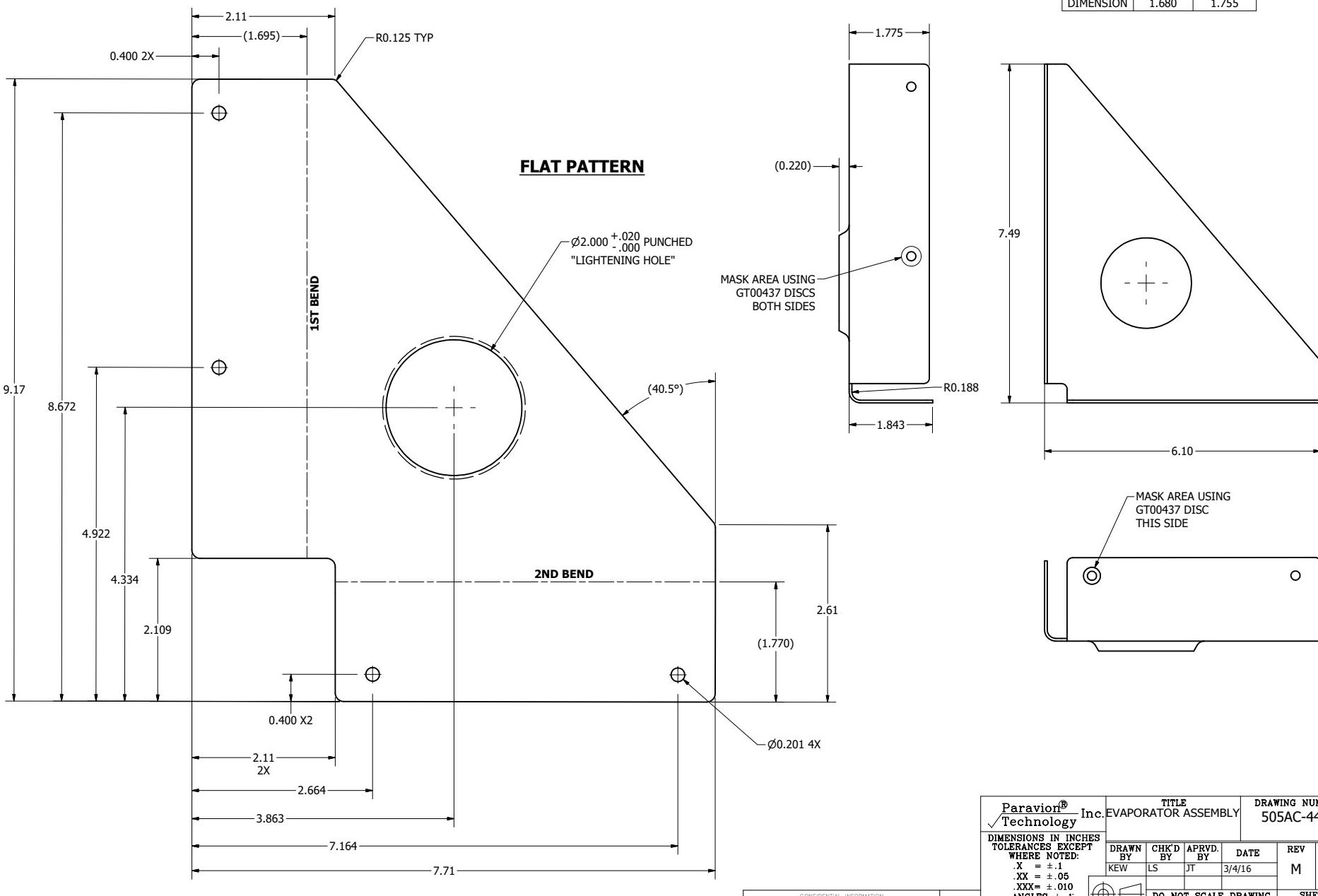
MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:  10

	BEND CHART	
	1st BEND	2nd BEND
PUNCH	#10	#10
DIE	#20	#20
ANGLE	80°	78°
DIMENSION	1.680	1.755

**BREAK ALL SHARP EDGES**

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PROTO

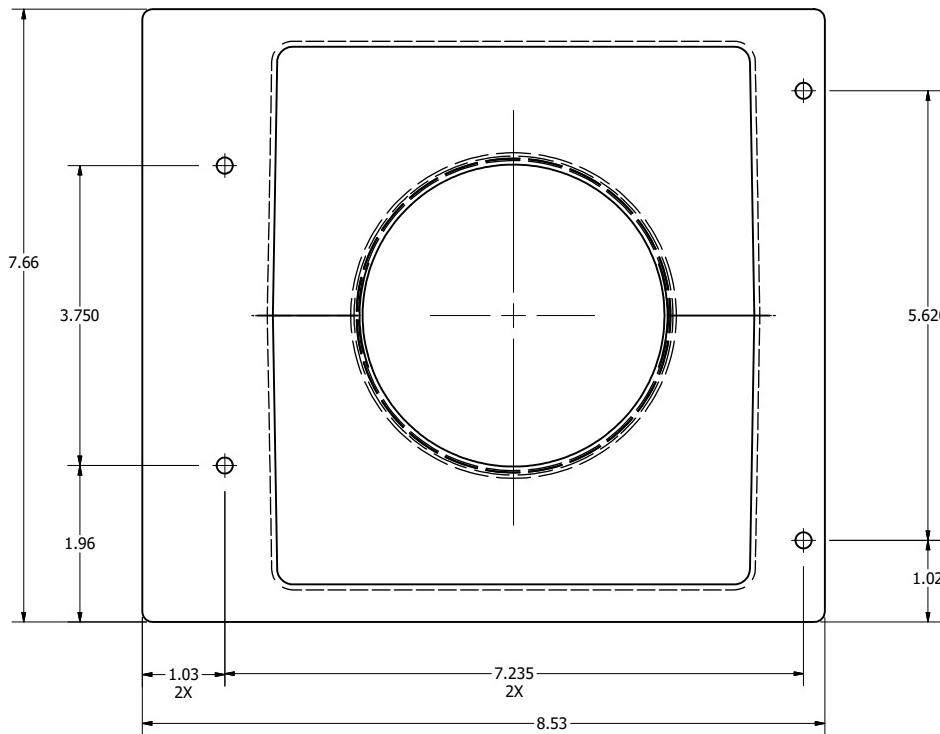
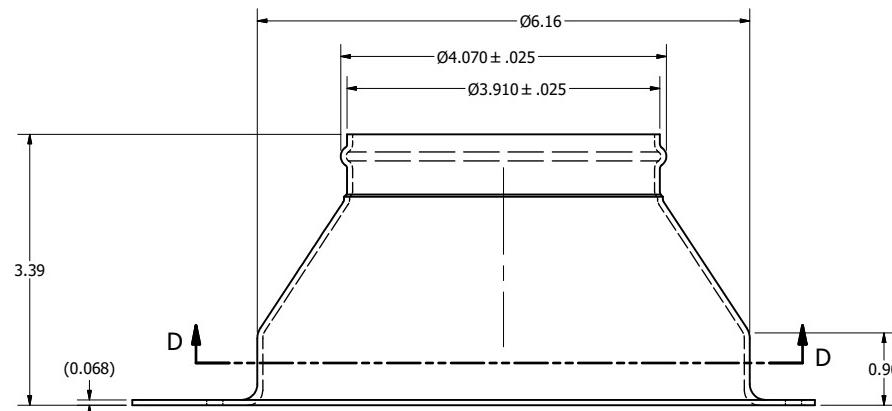
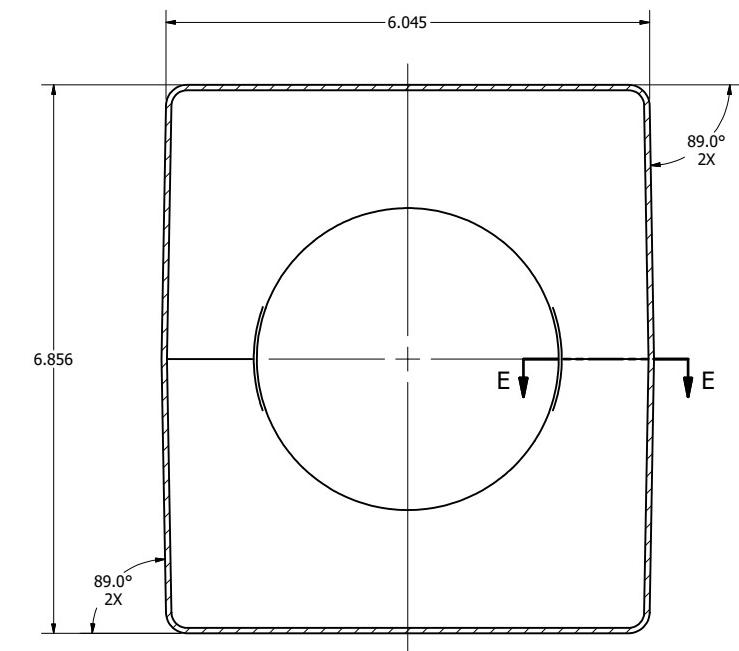
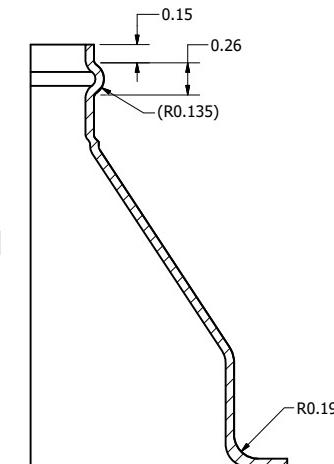
Paravion® Inc. Technology	TITLE EVAPORATOR ASSEMBLY	DRAWING NUMBER 505AC-4400
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		
DRAWN BY KEW	CHK'D BY LS	APPVD BY JT
DATE 3/4/16	REV M	ECO
DO NOT SCALE DRAWING		
SHEET 17 OF 25		
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		
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-34 EVAP INLET COWL

MATERIAL: KYDEX 100 SHEET, P-1 TEXTURE, COLOR: BLACK 52000

VENDOR: PLASTIC CREATIONS

VENDOR P/N: 505AC-4400-34V

**SECTION E-E****SECTION D-D**

NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-4400-22 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\Delta 0.040"$. THE DRAWING IS THE DESIGN MASTER. ANY FEATURE DEFINED ON THE DRAWING SUPERCEDES ALL MODEL DEFINITION.

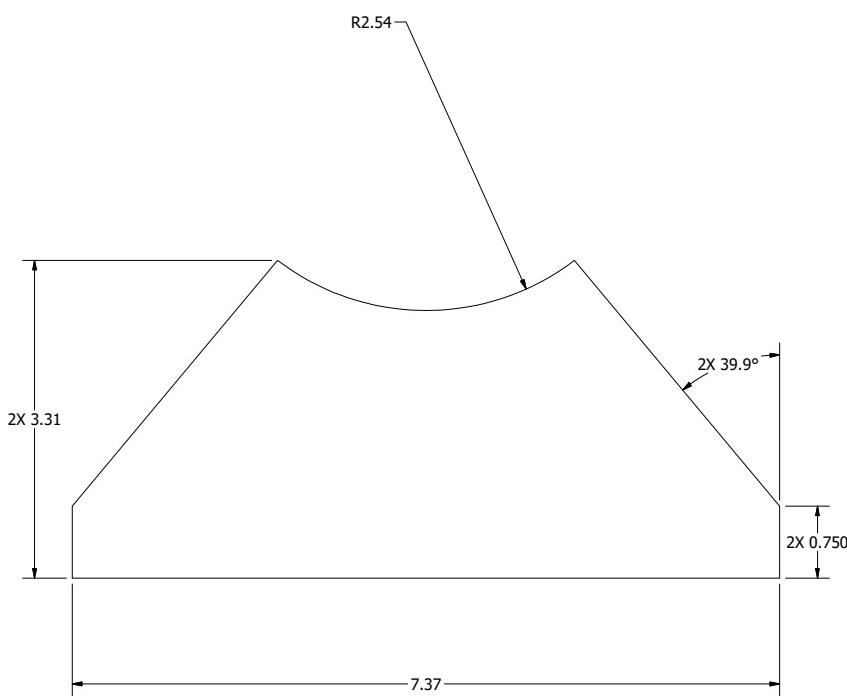
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PROTO

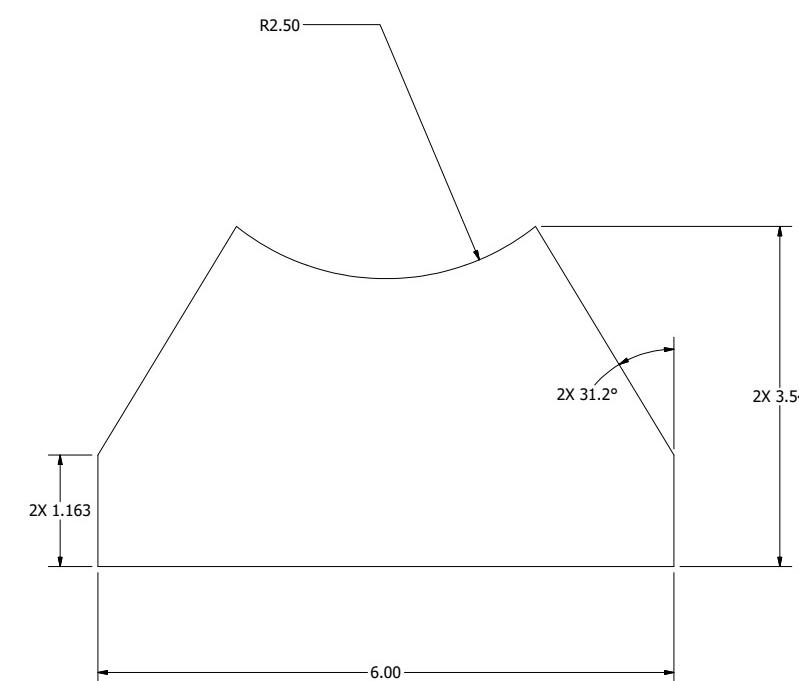
Paravion® Technology Inc.		TITLE		DRAWING NUMBER	
		EVAPORATOR ASSEMBLY		505AC-4400	
DRAWN BY	CHK'D BY	APPVD BY	DATE	REV	ECO
KEW	LS	JT	3/4/16	M	
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION		©2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY, INC.		SHEET 18 OF 25	

-35A EVAP INLET COWL INSULATION

MATERIAL: ES00135-2.

**-35B EVAP INLET COWL INSULATION**

MATERIAL: ES00135-2.



Paravion® Technology Inc.		TITLE EVAPORATOR ASSEMBLY		DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M	ECO
DO NOT SCALE DRAWING					
 PROTO		THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		SHEET 19 OF 25	
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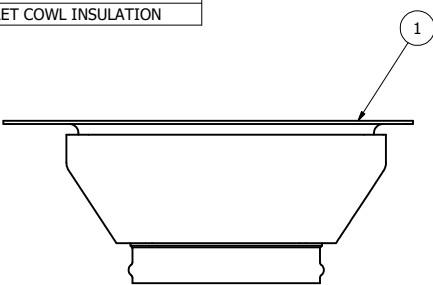
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-36 EVAP INLET COWL ASSEMBLY

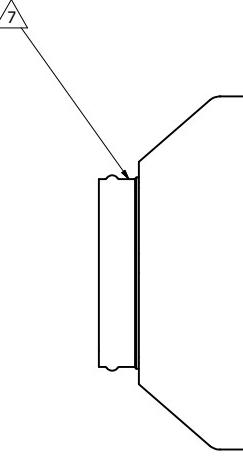
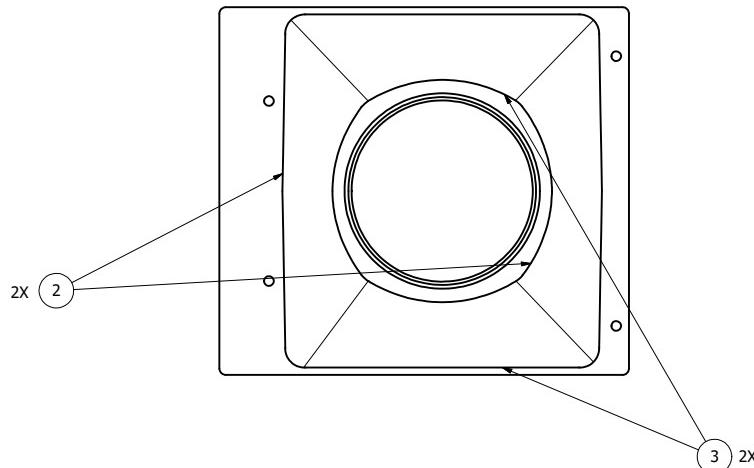
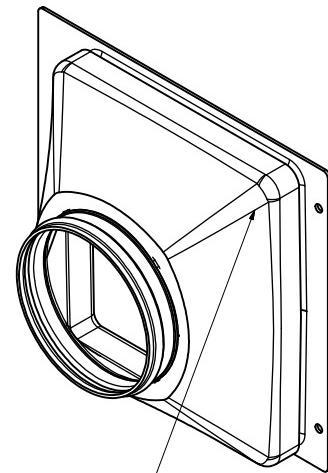
NOTES:

PREPARE SURFACE BY WIPING WITH ISOPROPYL ALCOHOL.

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-34	EVAP INLET COWL
2	2	505AC-4400-35A	EVAP INLET COWL INSULATION
3	2	505AC-4400-35B	EVAP INLET COWL INSULATION



SEAL MATING SURFACES WITH PEMATEX BLACK RTV #16B OR EQUIV.

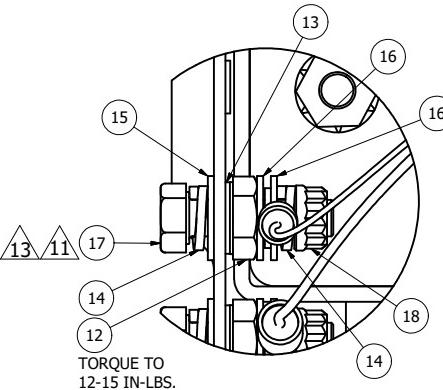
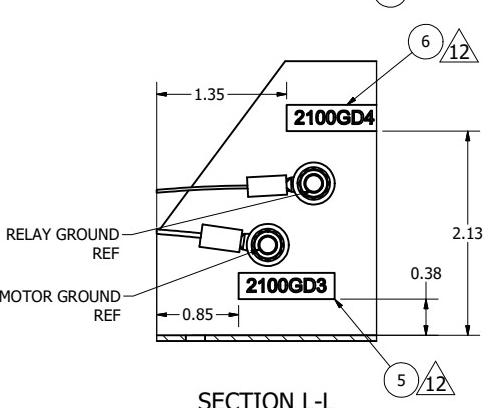
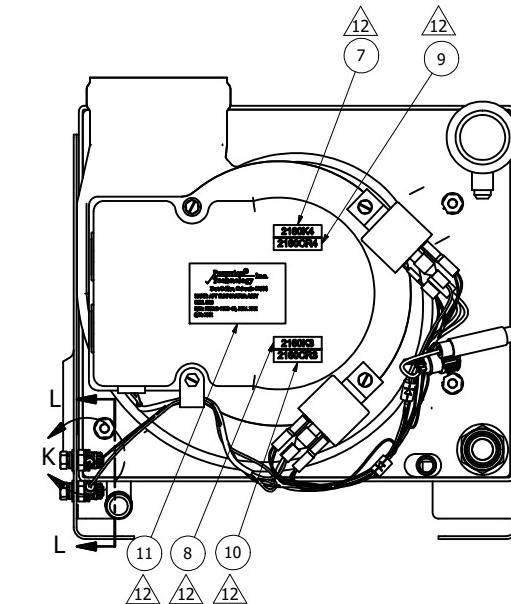
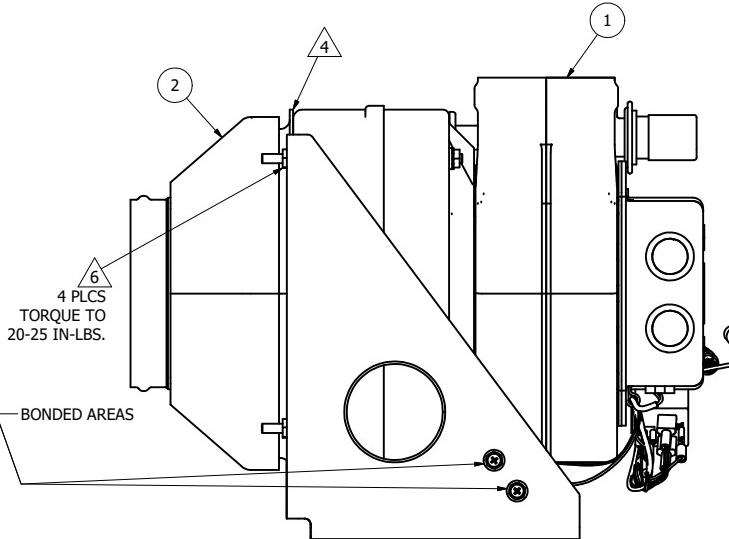
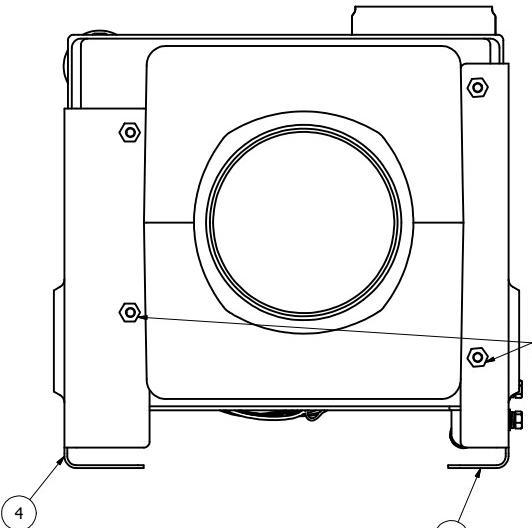
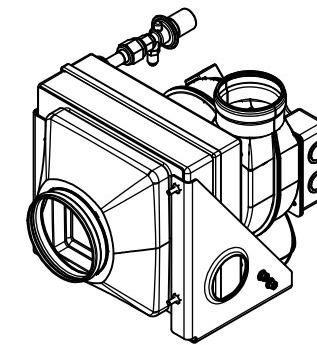


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PROTO

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DO NOT SCALE DRAWING					
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THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		3RD ANGLE PROJECTION		SHEET 20 OF 25	

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-12	AFT EVAPORATOR
2	1	505AC-4400-36	EVAP INLET COWL ASSEMBLY
3	1	505AC-4400-37	EVAPORATOR LEFT SIDE BRACE
4	1	505AC-4400-38	EVAPORATOR RIGHT SIDE BRACE
5	1	505AC-6120-13	2100GD3 DECAL
6	1	505AC-6120-14	2100GD4 DECAL
7	1	505AC-6120-26	2160K4 DECAL
8	1	505AC-6120-27	2160K3 DECAL
9	1	505AC-6120-28	2160CR4 DECAL
10	1	505AC-6120-29	2160CR3 DECAL
11	1	505AC-6120-6	LABEL
12	2	AN315-3R	NUT
13	2	MS35333-39P	LOCK WASHER
14	4	MS35338-43	SPLIT LOCK WASHER
15	2	NAS1149D0332J	WASHER
16	4	NAS1149F0332P	WASHER
17	2	NAS1801-3-12	SCREW
18	2	NAS9926-3L	LOCKING NUT

-40 AFT EVAPORATOR ASSY

DETAIL K
TYP. 2 PLCS

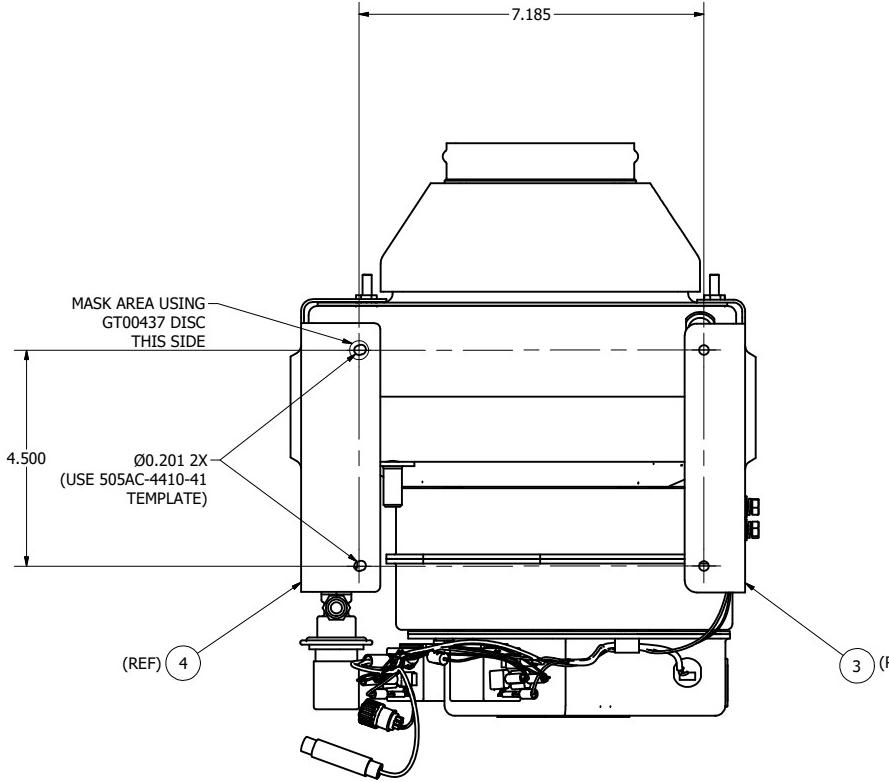
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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		EVAPORATOR ASSEMBLY		505AC-4400	
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DO NOT SCALE DRAWING					
INTERNAL CLASS 2B EXTERNAL CLASS 2A					
3RD ANGLE PROJECTION					
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SHEET
21 OF 25

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-12	AFT EVAPORATOR
2	1	505AC-4400-36	EVAP INLET COWL ASSEMBLY
3	1	505AC-4400-37	EVAPORATOR LEFT SIDE BRACE
4	1	505AC-4400-38	EVAPORATOR RIGHT SIDE BRACE
5	1	505AC-6120-13	2100GD3 DECAL
6	1	505AC-6120-14	2100GD4 DECAL
7	1	505AC-6120-26	2160K4 DECAL
8	1	505AC-6120-27	2160K3 DECAL
9	1	505AC-6120-28	2160CR4 DECAL
10	1	505AC-6120-29	2160CR3 DECAL
11	1	505AC-6120-6	LABEL
12	2	AN315-3R	NUT
13	2	MS35333-39P	LOCK WASHER
14	4	MS35338-43	SPLIT LOCK WASHER
15	2	NAS1149D0332J	WASHER
16	4	NAS1149F0332P	WASHER
17	2	NAS1801-3-12	SCREW
18	2	NAS9926-3L	LOCKING NUT

-40 AFT EVAPORATOR ASSY

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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		EVAPORATOR ASSEMBLY		505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING 3RD ANGLE PROJECTION		REV M ECO	
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-37 EVAPORATOR LEFT SIDE BRACE 9

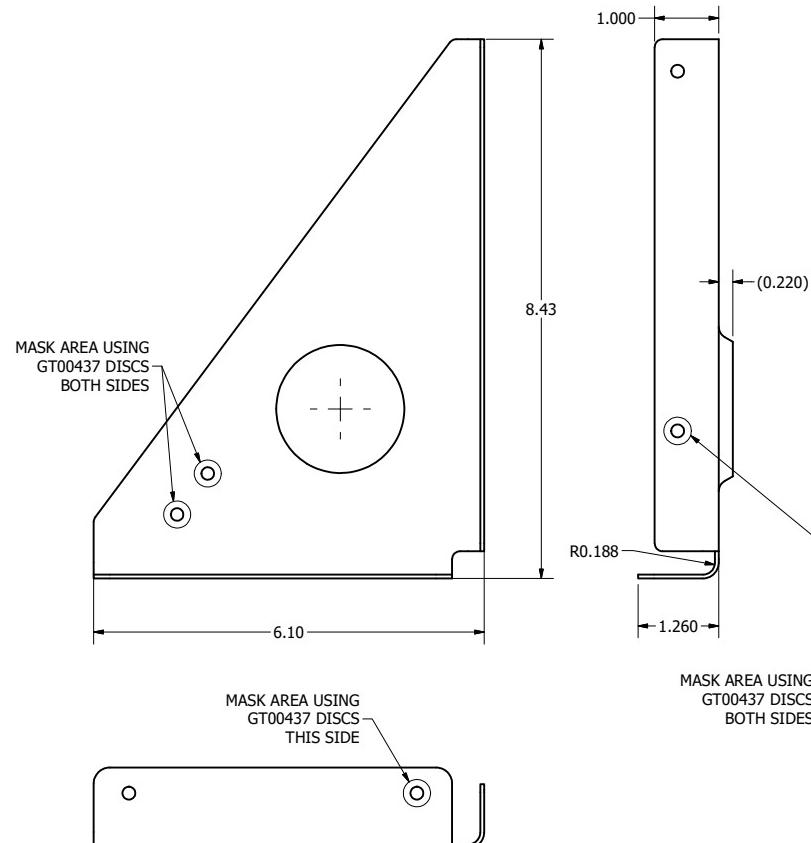
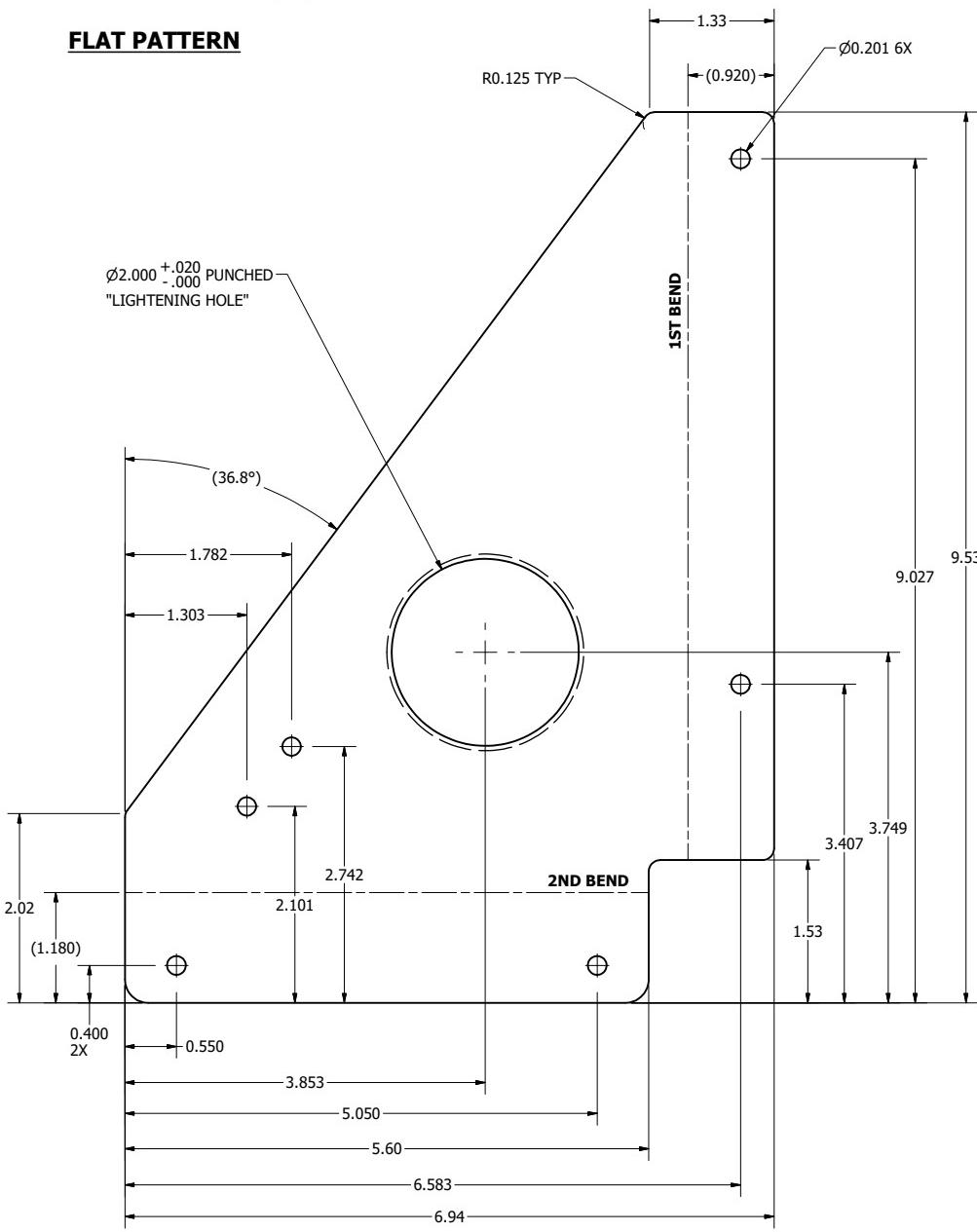
MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 10

	BEND CHART	
	1st BEND	2nd BEND
PUNCH	#10	#10
DIE	#20	#20
ANGLE	82°	82°
DIMENSION	.930	1.190

FLAT PATTERN**BREAK ALL SHARP EDGES**

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Paravion® Technology Inc.	TITLE		DRAWING NUMBER	
	EVAPORATOR ASSEMBLY		505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°				
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/4/16	REV M
DO NOT SCALE DRAWING				
SHEET 23 OF 25				
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A				
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-38 EVAPORATOR RIGHT SIDE BRACE ⁹

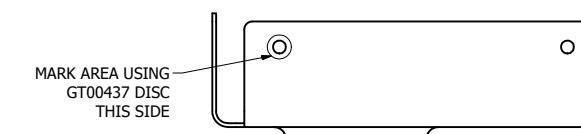
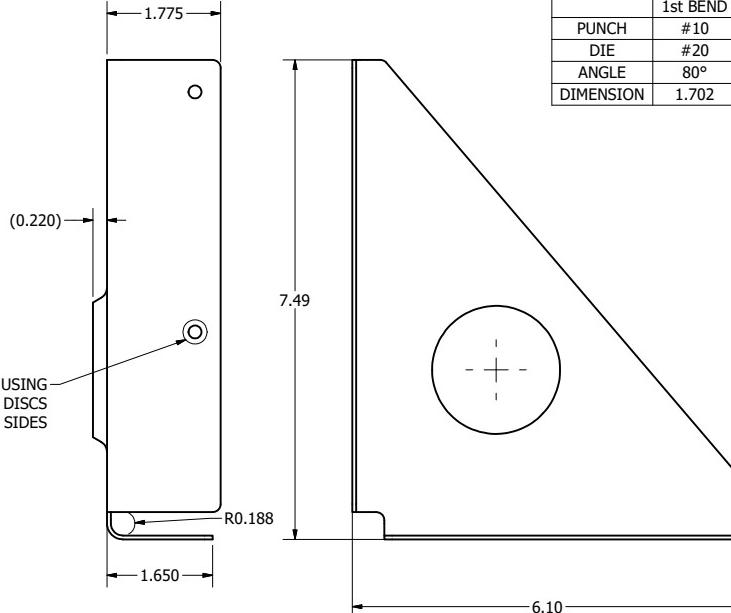
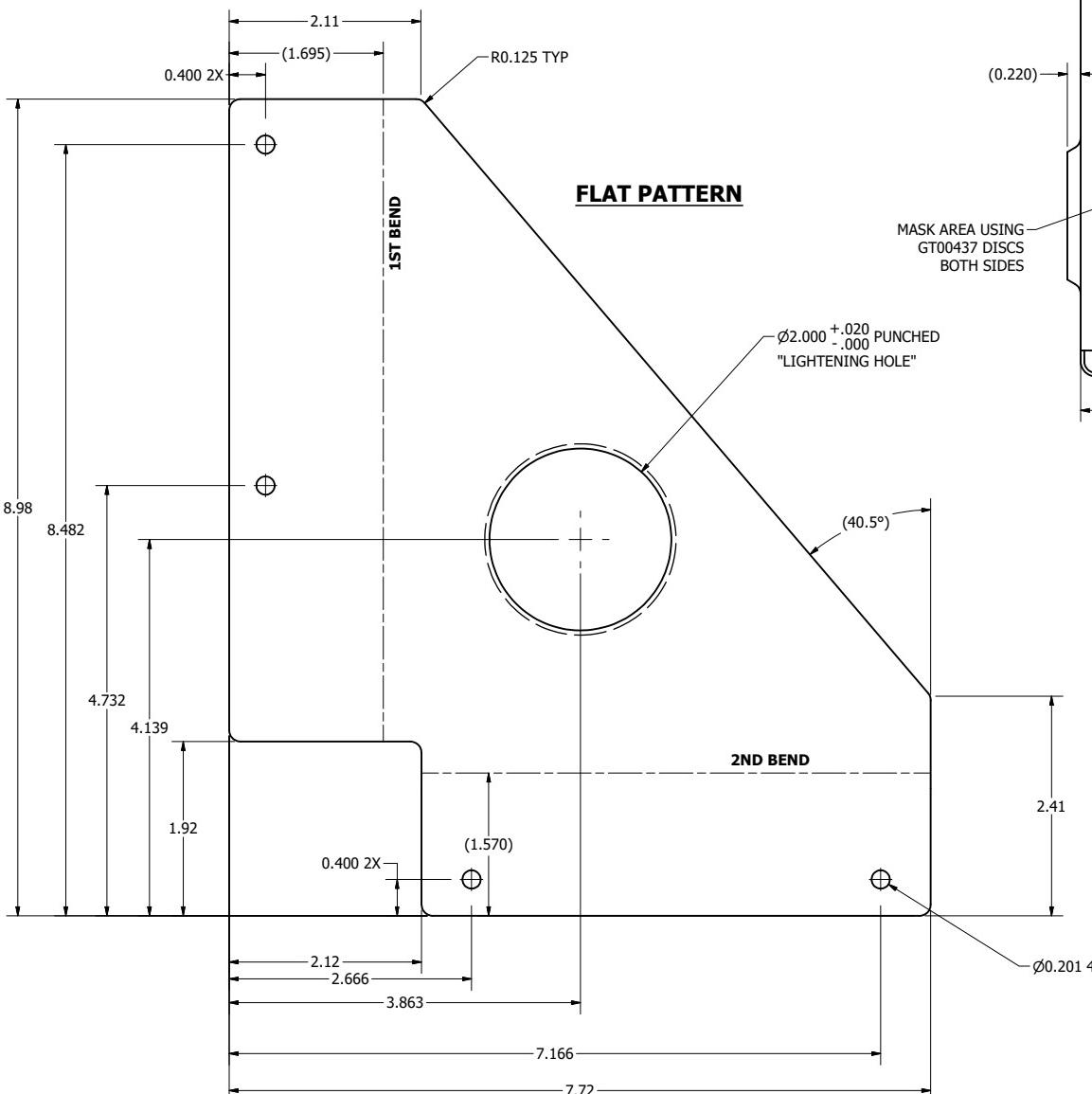
MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: ¹⁰

BEND CHART		
	1st BEND	2nd BEND
PUNCH	#10	#10
DIE	#20	#20
ANGLE	80°	78°
DIMENSION	1.702	1.577

**BREAK ALL SHARP EDGES**

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Paravion® Technology	TITLE EVAPORATOR ASSEMBLY			DRAWING NUMBER 505AC-4400	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
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DO NOT SCALE DRAWING					
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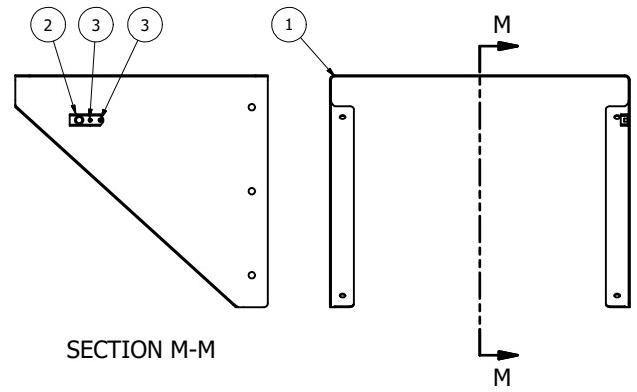
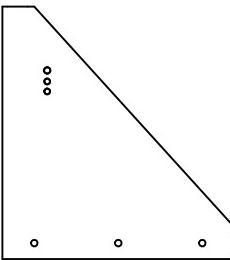
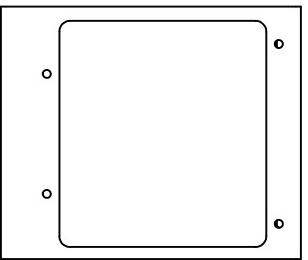
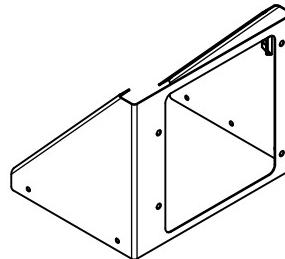
3RD ANGLE
PROJECTION

SHEET
24 OF 25

505AC-4400-41 LH EVAPORATOR MOUNT ASSY

NOTES: PAINT RIVET HEAD FLAT BLACK, MARKER ACCEPTABLE

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4400-2	LH EVAPORATOR MOUNT
2	1	MS21061L3	NUT PLATE ONE LEG FLOATING
3	2	MS20426AD3-3	RIVET



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